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## INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

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<b>(21) International Application Number:</b> PCT/US92/06733 <b>(22) International Filing Date:</b> 12 August 1992 (12.08.92)  <b>(30) Priority data:</b> 744,035 12 August 1991 (12.08.91) US 779,449 18 October 1991 (18.10.91) US  <b>(71) Applicant:</b> ALLIED-SIGNAL INC. [US/US]; 101 Columbia Road, P.O. Box 2245, Morristown, NJ 07962-2245 (US).  <b>(72) Inventors:</b> MAXFIELD, MacRae ; 1226 Cambridge Avenue, Plainfield, NJ 07062 (US). SHACKLETTE, Lawrence, W. ; 11 Alden Place, Maplewood, NJ 07040 (US). BAUGHMAN, Ray, H. ; 14 Glacier Drive, Morris Plains, NJ 07950 (US). CHRISTIANI, Brian, R. ; 139 Indiana Street, Maplewood, NJ 07040 (US). EBERLY, Daniel, E. ; 53 Rodtke Road, Randolph, NJ 07869 (US).		<b>(74) Agent:</b> ROONEY, Gerard, P.; Allied-Signal Inc., Attn: Law Dept. (C.A. McNally), 101 Columbia Road, P.O. Box 2245, Morristown, NJ 07962-2245 (US).  <b>(81) Designated States:</b> CA, JP, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, SE).  <b>Published</b> <i>With international search report.</i>
<b>(54) Title:</b> MELT PROCESS FORMATION OF POLYMER NANOCOMPOSITE OF EXFOLIATED LAYERED MATERIAL  <b>(57) Abstract</b>  This invention relates to a process of forming a polymeric nanocomposite comprising a continuous polymeric phase formed from a melt processible polymer and platelet particles having an average thickness equal to or less than about 50 Å, and the polymeric nanocomposite formed by said process.		

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MELT PROCESS FORMATION OF POLYMER NANOCOMPOSITE  
OF EXFOLIATED LAYERED MATERIAL

5    1.   Field of the Invention

          This invention relates to a process for forming a composite material comprising a polymer matrix having dispersed therein platelet particles, derived from swellable intercalated layered materials, and to  
10   composite material formed by the process of this invention. More particularly, this invention relates to such a process where the intercalated layered material has layers which are compatible with the polymer of the matrix, such that during the process the  
15   polymer-compatible layers of the intercalated material dissociate one from the other to form platelet fillers.

          2.   Prior Art

          A specific category of polymer nanocomposites has  
20   been described as a composite material comprising a polymer matrix containing a polyamide having uniformly dispersed therein layers of silicate. Such nanocomposites are described in US Pat No. 4,739,007 and No. 4,810,734, Deutsches Pat. 3808623 A1, Japanese  
25   Patent J 02 208358 A, and technical publications by the patentees (J. Inclusion Phenomena 5, (1987), 473-483; Clay Minerals, 23, (1988), 27; Polym. Preprints, 32, (April 1991), 65-66; and Polym. Prints, 28, (August 1987), 447-448.

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SUMMARY OF THE INVENTION

          This invention relates to a process for forming a polymeric composite which comprises platelet particles dispersed in a polymeric matrix which comprises the  
35   steps of:

          (a) forming a "flowabl mixture" comprising a melt-processible polymer and a swellabl and polymer-

compatible intercalated layered material having layers that are compatible with said polymer; and

(b) subjecting said mixture to a shear having a shear rate which is sufficient to dissociate all or a portion of said layers one from the other to form platelet particles having an average thickness equal to or less than about 50 Å, and preferably having a maximum thickness of 100 Å, and to uniformly disperse said platelet particles in said polymer to form said polymer composite.

Another aspect of this invention relates to a composite material comprising a polymeric matrix which comprises a melt processible polymer having uniformly dispersed therein platelet particles having an average thickness equal to or less than about 50 Å and preferably having a maximum thickness equal to or less than about 100 Å, said platelets having a chemical species bonded to the surface thereof and which is not covalently bonded to said polymer. The process is directed toward preparation of polymer composites wherein the dispersed phase comprises platelet particles having two flat opposite faces, the thickness of which particles is the distance between these faces. The thickness is relatively small compared to the size of the flat opposite faces. Dispersing such finely divided platelet particles imparts a very large area of contact between polymer and particles for a given volume of particles in the composite and a high degree of homogeneity of the composite with respect to the particular effect of the dispersed particles. Platelet particles of high strength and modulus, dispersed at sub-micron size (nanoscale), impart greater mechanical reinforcement to the polymer matrix than do comparable loadings of conventional reinforcing fillers of micron size. Nanoscale barrier layers impart lower perm ability to polymers than do comparable loadings of conventional barrier fillers.

The process of this invention exhibits several advantages over monomer blending and polymerizing processes of the type described in U.S. Patent Nos. 4,810,734 and 4,739,007, also referred to herein as in-reactor processes. These advantages include utility for a broader range of matrix polymers; utility for a wider range of composites having the same matrix polymer due to a larger selection of swelling/compatibilizing agents, each having a distinct bonding interaction with both the polymer and the platelet particle; and greater control over the molecular weight distribution of the matrix polymer. For example, virtually any polymer material that can be made to flow can be compounded with nanoscale particles derived from intercalated layered materials which exfoliate during mixing in accordance with the process of this invention. In contrast, the monomer blending and polymerizing processes of the prior art are restricted to polymers whose monomers are compatible with layered materials and can be polymerized effectively in the presence of the layered material. In the process of the present invention, the compounding entails no special conditions specific to selected polymer molecular weight distributions. On the other hand, in-reactor processes of the prior art require special polymerization conditions for each selected molecular weight distribution due to the effect of a dispersed phase on reaction mixture viscosity and polymerization kinetics. Virtually any loading of intercalated layered material is possible in the process of this invention, whereas in-reactor compounding of the prior art processes may be practically limited to loadings that permit polymerization to proceed to a selected molecular weight.

Another advantage is that compatibilizing agents including silane coupling agents can be readily used in

th process of this invention. These coupling agents can bond to the platelet particles through water- and chemical-resistant covalent bonds such as M-O-Si-C bonds, where M is a metal such as Si, Mg and Al. They can then couple the particles to the matrix polymer and other polymers via a variety of bonding interactions including covalent bonds, hydrogen-bonds, dipole-dipole bonds and interchain entanglement. Some of these silane coupling agents can not be used in monomer blending and polymerizing processes of the prior art. For example, silane coupling agents may hydrolyse or decompose under the polymerization conditions described in U.S. Patent Nos. 4,739,007 and 4,810,734. Specifically layered materials intercalated by swelling/compatibilizing agents which are compounded in the in-reactor blending processes of the prior art must survive polymerization conditions (e.g., several hours in water vapor at 250°C, or 30 minutes in strong reducing agents at 180°C, in the case of caprolactam polymerization by cationic and anionic processes, respectively). In contrast, only short high temperature exposures are required for the present process, such as about 1 minute at 250°C for compounding layered materials with nylon 6 to form a nanocomposite.

As a further advantage of the present process, unreacted monomer can be removed prior to forming the nanocomposite. This facilitates monomer removal, for example by solvent extraction, since dispersed particles can interfere with this process.

#### BRIEF DESCRIPTION OF THE DRAWINGS

The invention will be more fully understood and further advantages of the invention will become apparent when reference is made to the following detailed description of the invention and accompanying drawings in which:

FIG 1 is a graph of elastic modulus versus temperature for a nylon 6/montmorillonite nanocomposite.

FIG 2 is a graph of elastic modulus versus temperature for a nylon 6/montmorillonite nanocomposite and for a composite of nylon 6 with unintercalated montmorillonite.

FIG 3 is a micrograph of the extruded nanocomposite formed by the process of this invention of Example 3 obtained by transmission electron microscopy.

#### DESCRIPTION OF THE PREFERRED EMBODIMENTS OF THE INVENTION

The first step of this invention comprises forming a "flowable mixture" comprising one or more polymers in a "polymer melt" and at least one "swellable and polymer-compatible intercalated layered material" which comprises polymer-compatible layers that are compatible with said polymers. As used herein, a "flowable mixture" is a mixture which is capable of flowing at the submicron scale so that the layered materials may exfoliate into platelet particles comprising individual or a small multiple of layers, which may in turn disperse within the polymer mixture. As used herein, a "polymer melt" is a melt processible polymer or mixture of polymers which has been heated to a temperature sufficiently high to produce a viscosity low enough for submicron scale mixing to occur. Temperatures used in the first step are not critical and can be varied widely as desired provided that the polymer employed is in the state of a polymer melt. In the preferred embodiments of the invention, process temperature should be at least as high as the melting point of the particular polymer employed, and below the degradation temperature of the polymer. In the more preferred embodiments of this invention, where the polymer is a thermoplastic polymer, the process temperature is such



that the polymer will remain in the polymer melt during the conduct of the process. In the case of a crystalline thermoplastic polymers, the temperature is above the polymer's melting temperature. For example, a typical nylon 6 having a melting point of about 225°C can be melted in an extruder at any temperature equal to or greater than about 225°C, as for example between about 225°C and about 325°C. For nylon 6, a temperature of preferably from about 250°C to about 260°C is normally employed. In the cases of amorphous thermoplastics and vulcanizable rubbers, it is a temperature at which the viscosity is sufficiently low that processing of the polymer can be performed by conventional means.

The manner in which the flowable mixture is formed is not critical and conventional methods can be employed. For example, the flowable mixture can be prepared through use of conventional polymer and additive blending means, in which the polymer is heated to a temperature sufficient to form a polymer melt and combined with the desired amount of the intercalated layered material in a granulated or powdered form in a suitable mixer, as for example an extruder, a Banbury Mixer, a Brabender mixer, a continuous mixer and the like. The polymer melt containing nano-dispersed delaminated layered material may also be formed by reactive extrusion in which the layered material is initially dispersed as aggregates or at the nanoscale in a liquid or solid monomer and this monomer is subsequently polymerized in an extruder or the like. Such monomer or other reactive solid or liquid dispersion can be injected into a polymer melt containing one or more polymers in an extruder or other mixing device. The injected liquid may result in new polymer or in chain extension or grafting to the polymer initially in the melt. Alternatively, the polymer may be granulated and dry mixed with the

intercalated layered material, and thereafter, the composition may be heated in a mixer until the polymer is melted forming the flowable mixture. As described above, the flowable mixture is, in the second step, 5 subjected to a shear in a mixer sufficient to form the dispersed nanocomposite structure of platelet particles in the polymer melt, and it is thereafter cooled.

Best results are generally obtained when the flowable mixture includes as little water as possible 10 in order to avoid hydrolytic cleavage of the polymer and/or generation of void defects. Some polymers such as polyolefins can tolerate more than about 0.25% water by weight during melt processing, while others (such as condensation polymers as for example polyamides and 15 polyesters) may be degraded if processed with water content greater than about 0.1% by weight. Consequently, in the most preferred embodiments, both the polymer and the intercalated layered material are rigorously dried and contain substantially no water. 20 Ideally, the intercalated layered material is free of water that can be desorbed at temperatures up to the processing temperature. However, good results can be obtained when the intercalated layered material contains as much as about 2% by weight water and 25 comprises less than about 5% by weight of the flowable mixture. For compounding with condensation polymers, the intercalated layered material preferably contains less than about 1% by weight, more preferably less than about 0.5% by weight water and most preferably 30 less than about 0.25% by weight water.

As a first essential ingredient, the flowable mixture includes a "swellable and polymer-compatible intercalated material". As used herein, a "swellable and polymer-compatible intercalated layered material" 35 is a swellable layered material intercalated by a neutral or ionic intercalant or intercalants which act to weaken the interlayer cohesive energy by swelling

the interlayer distances. In the preferred embodiments of the invention, the intercalant or intercalants increase the compatibility and bonding of the layers with the polymer melt by having attractive interactions with both the layers and the polymer. Intercalants which function to swell interlayer distances are hereinafter referred to as "swelling agents", intercalants which function to increase the compatibility and bonding of the layers with the polymer melt are hereinafter referred to as "compatibilizing agents" and intercalants which function as swelling agents and compatibilizing agents are hereinafter referred to as "swelling/compatibilizing agents".

Swellable layered materials are materials comprising planar layers arrayed in a coherent, coplanar structure, where the bonding within the layers, is stronger than the bonding between the layers such that the materials exhibit increased interlayer spacing in their intercalation compounds. The neutral or ionic molecules, called "intercalants", may be introduced into the interlayer spaces by either insertion, in the case of neutral molecules, or ion exchange, in the case of ions. The intercalants may be introduced in the form of a solid, liquid, gas, or solute. The intercalants may be introduced into the spaces between every layer, nearly every layer, or a large fraction of the layers of the layered material such that the resulting platelet particles comprise less than about 10 layers in thickness. The platelet particles are preferably less than about 8 layers in thickness, more preferably less than about 5 layers in thickness, and most preferably, about 1 or 2 layers in thickness.

Any swellable layered material having the above referenced characteristics may be used in the practice of this invention. Useful swellable layered materials

includ phyllosilicates. Illustrative f such materials ar sm ctit clay minerals such as montmorillonite, nontronite, beidellite, volkonskoit , hectorite, saponite, sauconite, magadiite, and kenyaite; vermiculite; and the like. Other useful layered materials include illite minerals such as ledikite and admixtures of illites with the clay minerals named above. Other useful layered materials, particularly useful with anionic polymers, are the layered double hydroxides, such as  $Mg_6Al_{3.4}(OH)_{18.8}(CO_3)_{1.7} \cdot H_2O$  (see W.T. Reichle, J. Catal., 94 (12985) 547), which have positively charged layers and exchangeable anions in the interlayer spaces. Other layered materials having little or no charge on the layers may be useful in this invention provided they can be intercalated with swelling agents which expand their interlayer spacing. Such materials include chlorides such as  $ReCl_3$  and  $FeOCl$ , chalcogenides such as  $TiS_2$ ,  $MoS_2$ , and  $MoS_3$ , cyanides such as  $Ni(CN)_2$ , and oxides such as  $H_2Si_2O_5$ ,  $V_6O_{13}$ ,  $HTiNbO_3$ ,  $Cr_{0.5}V_{0.5}S_2$ ,  $W_{0.2}V_{2.8}O_7$ ,  $Cr_3O_8$ ,  $MoO_3(OH)_2$ ,  $VOPO_4 \cdot 2H_2O$ ,  $CaPO_4CH_3 \cdot H_2O$ ,  $MnHAsO_4 \cdot H_2O$ ,  $Ag_6Mo_{10}O_{33}$ , and the like. Preferred swellable layered materials are phyllosilicates of the 2:1 type having a negative charge on the layers ranging from about 0.25 to about 0.9 charges per formula unit and a commensurate number of exchangeable cations in the interlayer spaces. Most preferred layered materials are smectite clay minerals such as montmorillonite, nontronite, beidellite, volkonskoite, hectorite, saponite, sauconite, magadiite, and kenyaite.

Swellable layered materials, such as the preferred smectite clay materials generally require treatment by one or more intercalants to provide the required interlayer swelling and/or polymer compatibility. The resulting interlayer spacing is critical to the performanc of th intercalated layered material in the practic of this invention. As used herein the "inter-

layer spacing" refers to the distance between the faces of the layers as they are assembled in the intercalated material before any delamination (or exfoliation) takes place. The preferred clay materials generally include interlayer or exchangeable cations such as  $\text{Na}^+$ ,  $\text{Ca}^{+2}$ ,  $\text{K}^+$ ,  $\text{Mg}^{+2}$  and the like. In this state, these materials do not delaminate in host polymer melts regardless of mixing, because their interlayer spacings are usually equal to or less than about 4 Å consequently the interlayer cohesive energy is relatively strong. Moreover, the metal cations do not aid compatibility between layers and the polymer melt. In the preferred embodiments, these layered materials are intercalated by swelling agents of sufficient size to increase interlayer distances to the desired extent. In general, the interlayer distance should be at least about 4 Å, as determined by x-ray diffraction, in order to facilitate delamination of the layered material at the nanoscale. In the preferred embodiments of the invention, the interlayer distance is at least about 8 Å and more preferred interlayer distances are at least about 15 Å. In these preferred embodiments, the swelling agent is an ionic species which is capable of exchanging with the interlayer cations such as  $\text{Li}^+$ ,  $\text{Na}^+$ ,  $\text{K}^+$ ,  $\text{Mg}^{+2}$ , and  $\text{Ca}^{+2}$  and is of sufficient size to provide the required interlayer distance. Such ionic species include  $\text{NH}_4^+$ ,  $\text{Al}^{+3}$ ,  $\text{Cu}^{+2}$ ,  $\text{Fe}^{+3}$ ,  $\text{NH}_2\text{R}^1$ ,  $\text{NH}_2\text{R}^1\text{R}^2$ ,  $\text{NHR}^1\text{R}^2\text{R}^3$ ,  $\text{NR}^1\text{R}^2\text{R}^3\text{R}^4$ , where the  $\text{R}^1$ ,  $\text{R}^2$ ,  $\text{R}^3$  and  $\text{R}^4$  are the same or different and are organic substituents, and the like.

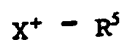
In order to further facilitate delamination of layered materials into platelet particles and prevent reaggregation of the particles, these layers are preferably polymer-compatible. In cases where the polymer melt is not compatible with the layers, the swellable layered material is intercalated by compatibilizing agents which consist of a portion which

bonds to the surface of the layers and another portion which bonds or interacts favorably with the polymer.

In some instances, intercalants are used which are swelling/compatibilizing agents which provide both the swelling function and the compatibilization function. Such agents preferably include a moiety or moieties which interact with the surface of the layers displacing, totally or in part, the original metal ions and which bonds to the surface of the layers; and includes a moiety or moieties whose cohesive energies are sufficiently similar to that of the polymer that the surface of the platelets is made more compatible with the polymer, thereby enhancing the homogeneity of the dispersion in the polymeric matrix. As used herein "compatible" refers to the extent to which the polymer matrix and the surface coating on the platelet particles (the compatibilizing agent) have a favorable interaction which promotes the intermingling of the matrix polymer and the surface layer in the interphase region. Compatibility derives from one or more of the following criteria: similar cohesive energy densities for the polymer and the derivatized platelets, similar or complimentary capacities for dispersive, polar, or hydrogen bonding interactions, or other specific interactions, such as acid/base or Lewis-acid/Lewis-base interactions. Compatibilization will lead to an improved dispersion of the platelet particles in the matrix and an improved percentage of delaminated platelets with a thickness of less than 50 Å.

The nature of the swelling/compatibilizing agent, swelling agent and/or compatibilizing agent will vary widely depending on the particular polymer and the particular layered material. For example, where the swellable layered material is a phyllosilicate as for example a smectite clay and the polymer is a polyolefin, polyester or polyamide such as polyethylene, polypropylene, poly(caprolactam) and

poly(ethylene terephthalate), swelling/compatibilizing agents are preferably zwitterionic and cationic surfactant type molecules, and most preferably cationic surfactant type materials. Useful cationic surfactants include onium species such as ammonium (primary, secondary, tertiary, and quaternary), phosphonium or sulfonium derivatives of aliphatic, aromatic or arylaliphatic amines, phosphines and sulfides. Illustrative of such materials are oxonium compounds of the formula:



where  $X^+$  is an ammonium, sulfonium or phosphonium radical such as  $-NH_3^+$ ,  $-N(CH_3)_3^+$ ,  $-N(CH_3)_2(CH_2CH_3)^+$ ,  $+S(CH_3)_3$ ,  $-P(CH_3)_3$ ,  $-NH_4^+$  (where  $R^5$  is  $-(CH_2)_n$ ), and the like and  $R^5$  is an organic radical as for example substituted or unsubstituted alkyl, cycloalkenyl, cycloalkyl, aryl, or alkylaryl, either unsubstituted or substituted with amino, alkylamino, dialkylamino, nitro, azido, alkenyl, alkoxy, cycloalkyl, cycloalkenyl, alkanoyl, alkylthio, alkyl, aryloxy, arylalkylamino, alkylamino, arylamino, dialkylamino, diarylamino, aryl, alkylsulfinyl, aryloxy, alkylsulfinyl, alkylsulfonyl, arylthio, arylsulfinyl, alkoxycarbonyl, arylsulfonyl, alkylsilane, and a moiety of the formula:



wherein  $R^6$  is alkyl, cycloalkyl, aryl,  $R'$  is hydrogen, alkyl, or aryl, and  $Z$  is  $-O-$  or  $-NR^7-$ , where  $R^7$  is hydrogen, alkyl, aryl or alkylsilane. Illustrative of useful  $R^5$  groups are hydrogen, alkyl, such as methyl, ethyl, octyl, nonyl, tert-butyl, neopentyl, isopropyl, sec-butyl, dodecyl and the like; alkenyl such as 1-propenyl, 1-butenyl, 1-pentenyl, 1-hexenyl, 1-heptenyl, 1-octenyl and the like; alkoxy such as

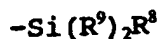
propoxy, butoxy, methoxy, isopropoxy, pentoxy, nonoxy, ethoxy, octoxy, and the like; cycloalkenyl such as cyclohexenyl, cyclopentenyl and the like; alkanoylalkyl such as butanoyl octadecyl, pentanoyl nonadecyl, 5 octanoyl pentadecyl, ethanoyl undecyl, propanoyl hexadecyl and the like; amino; alkylaminoalkyl, such as methylamino octadecyl, ethylamino pentadecyl, butylamino nonadecyl and the like; dialkylaminoalkyl, such as dimethylamino octadecyl, methylethylamino 10 nonadecyl and the like; arylaminoalkyl such as phenylamino octadecyl, p-methylphenylamino nonadecyl and the like; diarylaminoalkyl, such as diphenylamino pentadecyl, p-nitrophenyl-p'-methylphenylamino octadecyl and the like; alkylarylaminokyl, such as 15 2-phenyl-4-methylamino pentadecyl and the like; alkylsulfinyl, alkylsulfonyl, alkylthio, arylthio, arylsulfinyl, and arylsulfonyl such as butylthio octadecyl, neopentylthio pentadecyl, methylsulfinyl nonadecyl, benzylsulfinyl pentadecyl, phenylsulfinyl 20 octadecyl, propylthiooctadecyl, octylthio pentadecyl, nonylsulfonyl nonadecyl, octylsulfonyl hexadecyl, methylthio nonadecyl, isopropylthio octadecyl, phenylsulfonyl pentadecyl, methylsulfonyl nonadecyl, nonylthio pentadecyl, phenylthio octadecyl, ethylthio 25 nonadecyl, benzylthio undecyl, phenethylthio pentadecyl, sec-butylthio octadecyl, naphthylthio undecyl and the like; alkoxycarbonylalkyl such as methoxycarbonyl, ethoxycarbonyl, butoxycarbonyl and the like; cycloalkyl such as cyclohexyl, cyclopentyl, 30 cyclo-octyl, cycloheptyl and the like; alkoxyalkyl such as methoxy-methyl, ethoxymethyl, butoxymethyl, propoxyethyl, pentoxybutyl and the like; aryloxyalkyl and aryloxyaryl such as phenoxyphenyl, phoxymethyl and the like; aryloryalkyl such as phenoxydecyl, 35 phenoxyoctyl and the like; arylalkyl such as benzyl, phenethyl, 8-phenyloctyl, 10-phenyldecyl and the like; alkylaryl such as 3-decylphenyl, 4-octylphenyl, 4-



nonylphenyl and the like; and polypropylene glycol and polyethylene glycol substituents such as ethyl, propyl, butyl, phenyl, benzyl, tolyl, p-styryl, p-phenylmethyl chloride, octyl, dodecyl, octadecyl, methoxy-ethyl, 5 moieties of the formula  $-C_3H_6COOH$ ,  $-C_5H_{10}COOH$ ,  $-C_7H_{10}COOH$ ,  $-C_7H_{14}COOH$ ,  $-C_9H_{18}COOH$ ,  $-C_{11}H_{22}COOH$ ,  $-C_{13}H_{26}COOH$ ,  $-C_{15}H_{30}COOH$  and  $-C_{17}H_{34}COOH$  and  $CH=C(CH_3)COOCH_2CH_2-$ , and the like. Such ammonium, sulfonium and phosphonium radicals are well known in the art and can be derived from the 10 corresponding amines, phosphines, and sulfides.

Useful swelling/compatibilizing agents also include neutral compounds. For example useful swelling/compatibilizing agents include neutral amine, phosphine, and sulfide forms of the above-referenced 15 oxonium compounds which hydrogen bond to the layers. In this case, the original metal cations are not replaced.

Another class of swelling/compatibilizing agents are those which are covalently bonded to the layers. 20 Illustrative of such groups useful in the practice of this invention are silane coupling agents of the formula:



25 where  $R^9$  is the same or different at each occurrence and is alkyl, alkoxy or oxysilane such as trialkoxysilane compounds as for example octadecyltrimethoxysilane, gamma-aminopropyltriethoxysilane, gamma-aminopropyltrimethoxysilane, 30 gamma-aminopropylphenyldimethoxysilane, gamma-glycidoxypropyl tripropoxysilane, 3,3-epoxycyclohexylethyl trimethoxysilane, gamma-propionamido trithoxysilane, N-trimethoxysilylpropyl-N(beta-aminoethyl) amine, trimethoxysilylundecylamine, 35 trimethoxy silyl-2-chloromethylphenylethane, trimethoxysilyl- thylphenylsulfonlazide, N-trimethoxysilylpropyl-N,N,N-trimethylammonium chloride,

N-(trimethoxysilylpropyl)-N-methyl-N,N-diallylammonium chloride, trimethoxysilylpropylcinnamate, 3-mercaptopropyl trimethoxysilane, 3-isocyanatopropyl-triethoxysilane, and the like; and R<sup>8</sup> is selected from  
5 the group consisting of organic radicals which are compatible with the polymer forming the composite.

In other instances, it is convenient to use a compatibilizing agent that is different from the swelling agent. For example, alkylammonium cations may  
10 be used to replace the metal cations of a smectite mineral, and be partially replaced, in turn, by a silane coupling agent. In this case, the alkylammonium cation functions as a general purpose swelling agent while the silane can function as a compatibilizing  
15 agent that is highly specific to a selected polymer system.

In the preferred embodiments of the invention, the swelling agent, compatibilizing agent and/or swelling/compatibilizing agent will include a moiety  
20 which bonds to the surface of the layered material and will not be reactive with the polymer. Preferably the agent will also include a moiety which does not bond with the layered material and which is compatible with the polymer. In the preferred embodiments of this  
25 invention, swelling/compatibilizing agents are employed, especially onium agents and silane agents. In the preferred embodiments of the invention lipophilic swelling and compatibilizing agents are used. Such agents will preferably include a lipophilic  
30 portion as for example a long chain alkyl, alkenyl or alkylaryl group (preferably of more than about 9 aliphatic carbon atoms). Such agents are well known in the art and include silane compounds and the ammonium, sulfonium and phosphonium derivatives of  
35 octadecylamine, octadecylphosphine, trimethyl dodecyl sulfide, octadecylsulfide, dimethyldidodecyl amin ,

octadecylamine, dioctylphosphine, methyloctadecylamine, dioctylsulfine, decylsulfide and the like.

The preferred intercalated layered materials of the present art enables formation of nanocomposites with high molecular weight polymers. In such preferred cases, the polymer in the nanocomposites has substantially the same molecular weight distribution as obtained for the same polymer similarly processed in the absence of the intercalated material. In contrast, Fukushima et al. show in Clay Minerals, 23, (1988), 27 that the number average molecular weight obtained by the in-reactor process substantially decreases with increasing weight percent of the clay in nylon-6. Preferred for the present invention are nanocomposites of nylon 6 in which the number average molecular weight is about 15,000 and the ratio of weight average to number average molecular weight ( $M_w/M_n$ ) is less than 3.0. Especially preferred are those nanocomposites in which the number average molecular weight is above approximately 25,000. In contrast with these preferences, Fukushima et al., (Clay Minerals, 23, (1988), 27) teach that the  $M_n$  for in-reactor formed nylon nanocomposites decreases from 36,000 at 5.30 wt %  $\text{NH}_3^+(\text{CH}_2)_{10}\text{COOH}$ - montmorillonite loading ( $M_w/M_n=10.5$ ) to 15,000 ( $M_w/M_n=14.0$ ) at 18.2 intercalated wt% clay, and to 8,000 ( $M_w/M_n=11.7$ ) at 31.4 wt% of intercalated clay. For the purposes of this invention  $M_n$  and  $M_w$  are measured by gel permeation chromatography in m-cresol at 100°C and contributions in the distribution from unreacted caprolactam are excluded from  $M_n$  and  $M_w$  evaluations.

We surprisingly found that omega-aminoacids, the preferred swelling/compatibilizing agents of U.S. Patent Nos. 4,739,007 and 4,810,734, are not preferred as swelling/ compatibilizing agents for swellable clay minerals compound d into molten polymers. Omega-aminoacids do not separate the swellable clay mineral

layers by more than 4 Å, once the removable water has been eliminated from the intercalated layered material. Nor are omega-aminoacids lipophilic and they do not make the mineral layers hydrophobic, and cannot be easily dried prior to compounding. Thus, such aminoacid intercalated materials and other such intercalated materials which are intercalated by molecules which tend to lie flat against the layers of the silicate do not readily delaminate in the polymer melt. The resulting large particles and gels which are present in the final polymer composite lead to a reduction of mechanical strength, impact resistance and optical clarity. In contrast, swellable mineral layers swollen and compatibilized with lipophilic swelling/compatibilizing agents such as the onium salts of hydrocarbon amines, phosphines and sulfides (such as octadecylamine), and silane derivatives of hydrocarbons (such as octadecyl-trimethoxysilane) possess no hydrophilic group such as a carboxylate group which can also bond ionically or through hydrogen bonds to the silicate layers. As a result, the lipophilic agents provide interlayer spacings of more than about 4Å, preferably more than about 8Å, more preferably equal to or greater than about 10Å and most preferably equal to or greater than about 15 Å. These intercalants containing lipophilic moieties such as hydrocarbon moieties additionally make the layer surfaces hydrophobic so intercalated layered materials are readily dried. Consequently, layers intercalated by such lipophilic materials such as hydrocarbon onium salts and hydrocarbon silanes require less high shear mixing to exfoliate in a polymer melt, to form the desired dispersion and, during melt processing, desorb less water which can cause void defects and react to break polymer chains of condensation polymers such as polyamides, polyesters, polycarbonates, and the like by hydrolysis. Such preferred intercalants produce a

polymer composite which contains a high percentage (>95%) of silicate sheets which are dispersed on a nanoscale. These composites in general display superior strength, toughness, and optical clarity.

5       The amount of swelling agent/compatibilizing agent and swelling/compatibilizing agents intercalated into swellable layered materials useful in this invention may vary substantially provided that the amount is effective to swell and, preferably to compatibilize the  
10       layers of the intercalated layered material to the extent required to provide the desired substantially uniform dispersion. In the preferred embodiments of the invention where swelling/compatibilizing agents are employed, amounts of agents employed will preferably  
15       range from about 10 mmole/100 g of layered material to about 1000 mmole/100 g of layered material. More preferred amounts are from about 20 mmole/100 g to about 200 mmole/100 g. In the case of the preferred smectite clay minerals, the more preferred amounts are  
20       from about 80 mmole/100 g to about 120 mmole/100 g of layered material.

      Swellable and polymer-compatible intercalated layered material can be formed by any method. Preferably such materials are formed by intercalation  
25       of suitable agents or agents in the interlayer spaces of the swellable layered material by any suitable method. The swelling/compatibilizing agents are introduced into the interlayer spaces of the swellable layered material by any suitable method as, for  
30       example, by either insertion of neutral molecules or by ion exchange with ionic molecules, using conventional procedures. Insertion of neutral molecules may be performed by exposing finely divided layered material to intercalants in the form of a gas, neat liquid,  
35       finely divided solid, or solute in a solvent which, preferably swells the layered material. Insertion is generally aided by exposure of the mixture of

intercalant and layered material to heat, ultrasonic cavitation, or microwaves. Ion exchange by ionic molecules may be performed by suspending the layered material in a relatively volatile liquid which is

5 capable of both exfoliating and dispersing the layers of the intercalated layered material and dissolving a salt of the ionic intercalant as well as the resulting salt of the ion displaced from the layered material (e.g.,  $\text{Na}^+$ ,  $\text{Mg}^{+2}$ ,  $\text{Ca}^{+2}$ ), adding the salt of the ionic

10 intercalant, and removing the layered material (now complexed with the new intercalant) from the liquid (now containing the dissolved salt of the displaced ion). For example, swellable layered minerals such as montmorillonite and hectorite (having primarily  $\text{Na}^+$

15 cations in the interlayer spaces) intercalate water to the point that the layers are exfoliated and dispersed uniformly in water. Dispersion in water is generally aided by mixing with relatively high shear. A suitable swelling/compatibilization agent such as the

20 hydrochloride salt of dimethyldodecylamine is then added in the desired amount after which the layers complexed with the ammonium cation are separated from the dispersion, washed of residual  $\text{NaCl}$ , and dried. In the preferred embodiments of the invention, the

25 swellable layered material is intercalated by ion exchange. For example, a suspension of a montmorillonite or a saponite in water, may be heated to about  $80^\circ\text{C}$  and stirred using a high speed homogenizer mixer, in a concentration low enough to yield a low

30 viscosity dispersion from which non-dispersible particles can be separated by sedimentation (mineral concentration of about 2% by weight, or 5% to 15% with addition of a peptizing agent such as sodium hexametaphosphate). The dispersion is combined with a

35 solution of a suitable swelling/compatibilizing agent such as an ammonium salt (as, for example, the hydrochlorides of octadecylamine, 11-aminoundecanoic

acid, dioctylamine, dimethyldodecylamine, methyloctadecylamine, dimethyldidodecylamine, and the like) such that the mole ratio of ammonium salt to exchangeable ions in the mineral is between 0.5 and 5.

- 5 The amine-complexed layers may be separated from the solution by some suitable method such as filtration or centrifugation, followed by rinsing in fresh water, rough drying, and ball milling to about 100 mesh powder. The powder may be rigorously dried at 100°C to  
10 160°C in vacuum for 8 to 24 h in the presence of a drying agent such as phosphorous pentoxide, to provide the desired swellable/polymer compatible intercalated layered material.

- Intercalated layered materials intercalated with  
15 silanes may be formed by treating a swellable and polymer-compatible intercalated layered material already intercalated with an onium cation with a silane coupling agent in a swelling liquid, such as dioxane, glyme, diglyme, dimethylsulfoxide, methylethylketone,  
20 and the like, or by treating an aqueous suspension of a layered material with water-soluble silane coupling agents such as trialkoxysilanes. In the preferred embodiments, silane intercalated swellable/polymer compatible intercalated layered material is formed as  
25 follows: Onium-intercalated layered materials, preferably prepared as described above are suspended and swollen in a swelling organic liquid and treated with a trialkoxysilane. For example, montmorillonite intercalated with octadecylammonium cation, at about 80  
30 mmole of ammonium cation/100 g mineral, is combined with dioxane to form a 5% by weight suspension which is heated to 60°C and combined with a dioxane solution of aminoethylaminopropyl trimethoxysilane, such that the ratio of silane to mineral is about 20 mmole/100 g.  
35 The silane displaces the ammonium cation quantitatively to form a mixed intercalated layered material having

about 60 mmole of ammonium cation and 20 mmole of silane per 100 g of mineral layers.

In the preferred embodiments of this invention, swellable and polymer-compatible intercalated layered compounds include montmorillonite (Gelwhite HNF, Southern Clay Products) complexed with octadecylammonium cation (100 mmole/100 g mineral), montmorillonite complexed (Volclay, American Colloids Company) with N,N-dimethyloctadecylammonium cation (100 mmole/100 g), synthetic hectorite (Laponite S, Laporte Industries) complexed with dimethyldioctylammonium cation (80 mmole/100 g), commercially available organoclay (Claytone APA<sup>®</sup>, Southern Clay Products), montmorillonite complexed with octadecylammonium cation (about 80 mmole/g) and derivatized with aminoethylaminopropyltrimethoxysilane (20 mmole/100 g), and the like.

The amount of intercalated layered material included in the mixture may vary widely depending on the intended use of the composite. For example, relatively, larger amounts of platelet particles (exclusive of intercalant since the intercalant content in the layered material may vary), i.e. from about 15% to about 30% by wgt. of the mixture, are used in applications where articles are formed by stamping. Substantially enhanced barrier properties and heat resistance (deflection temperature under load, DTUL) are imparted by platelet particle concentrations greater than about 2.5%. Similarly, substantially enhanced strength is imparted by platelet particle concentrations greater than about 1.5%. When it is desired to preserve such properties as toughness (impact resistance) and elongation which are generally adversely affected by high loadings of any filler material including the nano-scale layered materials of this invention, it is preferred that the silicate loading be less than about 0.5%. Particle



concentration within the rang 0.05 to 0.5% significantly enhance modulus, dimensional stability, and wet strength (the latter in the case of polyamides). Concentrations below 0.5% can be employed to increase melt viscosity (useful in film extrusion and in fiber melt spinning) or they may be employed in selected polymers to stabilize a particular crystalline phase (useful in the case of nylon 6 to stabilize the gamma phase) or limit spherulite size which reduces haze and increases optical clarity. In general, the amount of material employed is less than about 60% by weight of the mixture. The amount of material employed is preferably from about 0.01% to about 20 % by weight of the mixture, more preferably from about 0.05% to about 10% by weight of the mixture, and most preferably from about 0.05% to about 8% by weight.

For preferred use in forming nanocomposites, the swelling/compatibilizing agent is selected so that when subjected to the processing temperature of the matrix polymer(s), it does not evolve decompositions products which can cause chain scission or other degradation of the matrix polymers. Special care must be taken when polymers which require high processing temperatures are used. For example, quaternary ammonium cations which start to thermally decompose, at about 220 to 260°C into alkenes and amines, may be preferred for use with polyvinyl chloride, polypropylene, and nylon 6, but not for polycarbonates. On the basis of thermal stability, silanes and onium cations, that cannot undergo beta-elimination are preferred, e.g., ammonium cations of the formula:



where  $R^{10}$  is hydrogen or an organic moiety,  $R^{11}$  is an organic moiety and  $R^{12}$  is the same or different at each occurrence and is an organic radical.

The second essential ingredient of the flowable mixture is a melt processible polymer. Polymers for

us in the process of this invention may vary widely, the only requirement is that they are melt processible. As used herein, a "polymer" in a substance composed of ten or more recurring monomeric units which may be the same or different. In the preferred embodiments of the invention, the polymer includes at least thirty recurring monomeric units. The upper limit to the number of recurring monomeric units is not critical, provided that the melt index of the polymer under use conditions is such that the polymer forms a flowable mixture. More preferably, the polymer includes at least from about 30 to about 100 recurring monomeric units. In the most preferred embodiments of this invention the number of recurring units is such that the polymer has a melt index of from about 0.01 to about 12 grams per 10 minutes at the processing temperature.

Useful polymers are thermoplastic polymers or mixtures thereof, and vulcanizable and thermoplastic rubbers. Thermoplastic resins for use in the practice of this invention may vary widely. Illustrative of useful thermoplastic resins are polylactones such as poly(pivalolactone), poly(caprolactone) and the like; polyurethanes derived from reaction of diisocyanates such as 1,5-naphthalene diisocyanate, p-phenylene diisocyanate, m-phenylene diisocyanate, 2,4-toluene diisocyanate, 4,4'-diphenylmethane diisocyanate, 3,3'-dimethyl-4,4'-diphenyl-methane diisocyanate, 3,3'-dimethyl-4,4'-biphenyl diisocyanate, 4,4'-diphenylisopropylidene diisocyanate, 3,3'-dimethyl-4,4'-diphenyl diisocyanate, 3,3'-dimethyl-4,4'-diphenylmethane diisocyanate, 3,3'-dimethoxy-4,4'-biphenyl diisocyanate, dianisidine diisocyanate, tolidine diisocyanate, hexamethylene diisocyanate, 4,4'-diisocyanatodiphenylmethane and the like and linear long-chain diols such as poly(tetramethylene adipate), poly(ethylene adipate), poly(1,4-butylene

adipate), poly(ethylene succinate), poly(2,3-butylene succinate), polyether diols and the like; polycarbonates such as poly[methane bis(4-phenyl carbonate)], poly[1,1-ether bis(4-phenyl) carbonate],  
5 poly[diphenylmethane bis(4-phenyl)carbonate], poly[1,1-cyclohexane bis(4-phenyl)carbonate] and the like; polysulfones; polyether ether ketones; polyamides such as poly(4-amino butyric acid), poly(hexamethylene adipamide),  
10 poly(6-aminohexanoic acid), poly(m-xylylene adipamide), poly(p-xylylene sebacamide), poly(2,2,2-trimethyl hexamethylene terephthalamide), poly(metaphenylene isophthalamide) (Nomex), poly(p-phenylene terephthalamide) (Kevlar), and the like; polyesters  
15 such as poly(ethylene azelate), poly(ethylene-1,5-naphthalate), poly(1,4-cyclohexane dimethylene terephthalate), poly(ethylene oxybenzoate) (A-Tell), poly(para-hydroxy benzoate) (Ekonol), poly(1,4-cyclohexylidene dimethylene terephthalate) (Kodel)  
20 (as), poly(1,4-cyclohexylidene dimethylene terephthalate) (Kodel) (trans), polyethylene terephthalate, polybutylene terephthalate and the like; poly(arylene oxides) such as poly(2,6-dimethyl-1,4-phenylene oxide), poly(2,6-diphenyl-1,4-phenylene  
25 oxide) and the like; poly(arylene sulfides) such as poly(phenylene sulfide) and the like; polyetherimides; vinyl polymers and their copolymers such as polyvinyl acetate, polyvinyl alcohol, polyvinyl chloride, polyvinyl butyral, polyvinylidene chloride, ethylene-  
30 vinyl acetate copolymers, and the like; polyacrylics, polyacrylate and their copolymers such as polyethyl acrylate, poly(n-butyl acrylate), polymethylmethacrylate, polyethyl methacrylate, poly(n-butyl methacrylate), poly(n-propyl methacrylate),  
35 polyacrylamide, polyacrylonitrile, polyacrylic acid, ethylene-acrylic acid copolymers, ethylene-vinyl alcohol c polymers acrylonitrile copolymers, methyl

methacrylate-styrene copolymers, ethylene-ethyl acrylate copolymers, methacrylated butadiene-styrene copolymers and the like; polyolefins such as low density poly(ethylene), poly(propylene), chlorinated low density poly(ethylene), poly(4-methyl-1-pentene), poly(ethylene), poly(styrene), and the like; ionomers; poly(epichlorohydrins); poly(urethane) such as the polymerization product of diols such as glycerin, trimethylol-propane, 1,2,6-hexanetriol, sorbitol, pentaerythritol, polyether polyols, polyester polyols and the like with a polyisocyanate such as 2,4-tolylene diisocyanate, 2,6-tolylene diisocyanate, 4,4'-diphenylmethane diisocyanate, 1,6-hexamethylene diisocyanate, 4,4'-dicyclohexylmethane diisocyanate and the like; and polysulfones such as the reaction product of the sodium salt of 2,2-bis(4-hydroxyphenyl) propane and 4,4'-dichlorodiphenyl sulfone; furan resins such as poly(furan); cellulose ester plastics such as cellulose acetate, cellulose acetate butyrate, cellulose propionate and the like; silicones such as poly(dimethyl siloxane), poly(dimethyl siloxane), poly(dimethyl siloxane co-phenylmethyl siloxane), and the like; protein plastics; and blends of two or more of the foregoing.

Vulcanizable and thermoplastic rubbers useful in the practice of this invention may also vary widely. Illustrative of such rubbers are brominated butyl rubber, chlorinated butyl rubber, polyurethane elastomers, fluoroelastomers, polyester elastomers, butadiene/acrylonitrile elastomers, silicone elastomers, poly(butadiene), poly(isobutylene), ethylene-propylene copolymers, ethylene-propylene-diene terpolymers, sulfonated ethylene-propylene-diene terpolymers, poly(chloroprene), poly(2,3-dimethylbutadiene), poly(butadiene-pentadiene), chlorosulfonated poly(ethylenes), poly(sulfide) elastomers, block copolymers, made up of segments of

glassy or crystalline blocks such as poly(styrene), poly(vinyl-toluene), poly(t-butyl styrene), polyester and the like and the elastomeric blocks such as poly(butadiene), poly(isoprene), ethylene-propylene copolymers, ethylene-butylene copolymers, polyether ester and the like as for example the copolymers in poly(styrene)-poly(butadiene)-poly(styrene) block copolymer manufactured by Shell Chemical Company under the trade name of Kraton®

Most preferred thermoplastic polymers are thermoplastic polymers such as polyamides, polyesters, and polymers of alpha-beta unsaturated monomers and copolymers. Polyamides which may be used in the process of the present invention are synthetic linear polycarbonamides characterized by the presence of recurring carbonamide groups as an integral part of the polymer chain which are separated from one another by at least two carbon atoms. Polyamides of this type include polymers, generally known in the art as nylons, obtained from diamines and dibasic acids having the recurring unit represented by the general formula:



in which R<sup>13</sup> is an alkylene group of at least 2 carbon atoms, preferably from about 2 to about 11 or arylene having at least about 6 carbon atoms, preferably about 6 to about 17 carbon atoms; and R<sup>14</sup> is selected from R<sup>13</sup> and aryl groups. Also, included are copolyamides and terpolyamides obtained by known methods, for example, by condensation of hexamethylene diamine and a mixture of dibasic acids consisting of terephthalic acid and adipic acid. Polyamides of the above description are well-known in the art and include, for example, the copolyamide of 30% hexamethylene diammonium isophthalate and 70% hexamethylene diammonium adipate, poly(hexamethylene adipamide) (nylon 6,6), poly(hexamethyl ne sebacamide) (nylon 6, 10), poly(hexamethylene isophthalamide), poly(hexamethylene

ter phthalamide), poly(heptamethylene pimelamide)  
(nyl n 7,7), poly(octamethylene suberamid ) (nylon  
8,8), poly(nonamethylene azelamide) (nylon 9,9) poly  
(decamethylene azelamide) (nylon 10,9),  
5 poly(decamethylene sebacamide) (nylon 10,10),  
poly[bis(4-amino cyclohexyl)methane-1,10-decane-  
carboxamide)], poly(m-xylene adipamide), poly(p-xylene  
sebacamide), poly(2,2,2-trimethyl hexamethylene  
terephthalamide), poly(piperazine sebacamide), poly(p-  
10 phenylene terephthalamide), poly(metaphenylene  
isophthalamide) and the like.

Other useful polyamides are those formed by  
polymerization of amino acids and derivatives thereof,  
as for example lactams. Illustrative of these useful  
15 polyamides are poly(4-aminobutyric acid) (nylon 4),  
poly(6-aminohexanoic acid) (nylon 6), poly(7-  
aminoheptanoic acid) (nylon 7), poly(8-aminooctanoic  
acid) (nylon 8), poly(9-aminononanoic acid) (nylon 9),  
poly(10-amino-decanoic acid) (nylon 10), poly(11-  
20 aminoundecanoic acid) (nylon 11), poly(12-  
aminododecanoic acid) (nylon 12) and the like.

Preferred polyamides for use in the practice of  
this invention are poly(caprolactam), poly(12-  
aminododecanoic acid) and poly(hexamethylene  
25 adipamide).

Other polymers which may be employed in the process  
of this invention are linear polyesters. The type of  
polyester is not critical and the particular polyesters  
chosen for use in any particular situation will depend  
30 essentially on the physical properties and features,  
i.e., tensile strength, modulus and the like, desired  
in the final form. Thus, a multiplicity of linear  
thermoplastic polyesters having wide variations in  
physical properties are suitable for use in the process  
35 of this invention.

The particular polyester chosen for use can be a  
homopolyester or a copolyester, or mixtures thereof

as desired. Polyesters are normally prepared by the condensation of an organic dicarboxylic acid and an organic diols, and, therefore, illustrative examples of useful polyesters will be described hereinbelow in terms of these diol and dicarboxylic acid precursors.

Polyesters which are suitable for use in this invention are those which are derived from the condensation of aromatic, cycloaliphatic, and aliphatic diols with aliphatic, aromatic and cycloaliphatic dicarboxylic acids and may be cycloaliphatic, aliphatic or aromatic polyesters.

Exemplary of useful cycloaliphatic, aliphatic and aromatic polyesters which can be utilized in the practice of their invention are poly(ethylene terephthalate), poly(cyclohexylenedimethylene terephthalate), poly(ethylene dodecate), poly(butylene terephthalate), poly[ethylene(2,7-naphthalate)], poly(methaphenylene isophthalate), poly(glycolic acid), poly(ethylene succinate), poly(ethylene adipate), poly(ethylene sebacate), poly(decamethylene azelate), poly(ethylene sebacate), poly(decamethylene adipate), poly(decamethylene sebacate), poly(dimethylpropiolactone), poly(para-hydroxybenzoate) (Ekonol), poly(ethylene oxybenzoate) (A-tell), poly(ethylene isophthalate), poly(tetramethylene terephthalate), poly(hexamethylene terephthalate), poly(decamethylene terephthalate), poly(1,4-cyclohexane dimethylene terephthalate) (trans), poly(ethylene 1,5-naphthalate), poly(ethylene 2,6-naphthalate), poly(1,4-cyclohexylidene dimethylene terephthalate), (Kodel) (cis), and poly(1,4-cyclohexylidene dimethylene terephthalate (Kodel) (trans).

Polyester compounds prepared from the condensation of a diol and an aromatic dicarboxylic acid are preferred for use in this invention. Illustrative of such useful aromatic carboxylic acids are terephthalic

acid, isophthalic acid and a o-phthalic acid, 1,3-napthal n dicarboxylic acid, 1,4-napthalen dicarboxylic acid, 2,6-napthalenedicarboxylic acid, 2,7-napthalenedicarboxylic acid, 4,4'-diphenyldicarboxylic acid, 4,4'-diphenysulfphone-dicarboxylic acid, 1,1,3-trimethyl-5-carboxy-3-(p-carboxyphenyl)-idane, diphenyl ether 4,4'-dicarboxylic acid, bis-p(carboxy-phenyl) methane and the like. Of the aforementioned aromatic dicarboxylic acids, those based on a benzene ring (such as terephthalic acid, isophthalic acid, orthophthalic acid) are preferred for use in the practice of this invention. Amongst these preferred acid precursors, terephthalic acid is particularly preferred acid precursor.

In the most preferred embodiments of this invention, poly(ethylene terephthalate), poly(butylene terephthalate), and poly(1,4-cyclohexane dimethylene terephthalate) are the polyesters of choice. Among these polyesters of choice, poly(ethylene terephthalate) is most preferred.

Still other useful and preferred thermoplastic homopolymers and copolymers are polymers formed by polymerization of alpha-beta-unsaturated monomers or the formula:



wherein:

$R^{15}$  and  $R^{16}$  are the same or different and are cyano, phenyl, carboxy, alkylester, halo, alkyl, alkyl substituted with one or more chloro or fluoro, or hydrogen. Illustrative of such preferred homopolymers and copolymers are homopolymers and copolymers of ethylene, propylene, vinylalcohol, acrylonitrile, vinylidene chloride, salts of acrylic acid, salts of methacrylic acid, tetrafluoroethylene, chlorotrifluoroethylene, vinyl chloride and the like. Preferred are poly(propyl n ), propylene cop lymers,



poly(ethylene) and ethylene copolymers. More preferred are poly(ethylene) and poly(propylene).

In the preferred embodiments of the invention, the polymers of choice are polymers and copolymers of olefins, polyesters, polyamides and blends thereof containing polyesters. In the particularly preferred embodiments of the invention, polymers and copolymers of ethylene, polyamides (preferably nylon 6 and nylon 66 and more preferably nylon 6), and blends thereof are used.

Some useful polymers may be naturally compatible with the underivatized layers of a layered material, such that the layered material requires only intercalation by a swelling agent to weaken its interlayer cohesive energy. These polymers include polyamides, polyesters, and other polymers having surface energies similar to that of the layers of the swellable layered materials.

The preferred polyamide useful in the preferred invention has a melt index from about 0.01 to about 10 grams/10 minutes, and preferably from 0.5 to 10 grams/10 minutes as measured by ASTM Test No. D-1238 at a load of 1000 grams at 235°C. Amongst these particularly preferred embodiments, most preferred are those embodiments in which the polyamide is nylon 6 or nylon 66, with nylon 6 being the polyamide of choice. The preferred homopolymers or copolymers of ethylene have a melt index of from about 0.01 to about 1.0 grams per 10 minutes, preferably from about 0.05 to about 0.8 grams per 10 minutes as measured according to ASTM Test No. D1238 at a load of 2160 grams at 190°C.

The mixture may include various optional components which are additives commonly employed with polymers. Such optional components include nucleating agents, fillers, plasticizers, impact modifiers, chain extenders, plasticizers, colorants, mold release lubricants, antistatic agents, pigments, fir

r tardants, and the like. These optional components and appropriate amounts are well known to those of skill in the art, accordingly, only the preferred optional components will be described herein in detail.

5 In the second step of the process of this invention, the flowable mixture is subjected to a shear having an "effective shear rate". As used herein, an "effective shear rate" is a shear rate [as shear rate is defined in Ferdinand Rodriguez, "Principles of  
10 Polymers Systems", McGraw-Hill Book Company, New York (1982)] which is effective to delaminate at least about 90% by weight of the intercalated material to form platelet particles described above, and provide a composition comprising a polymeric matrix having  
15 platelet particles substantially homogeneously dispersed therein. In the preferred embodiments of the invention, the shear rate is greater than about  $10 \text{ sec}^{-1}$ . In these preferred embodiments of the invention, the upper limit for the shear rate is not critical  
20 provided that the shear rate is not so high as to physically degrade the polymer. In the particularly preferred embodiments of the invention, the shear rate is from greater than about  $10 \text{ sec}^{-1}$  to about  $20,000 \text{ sec}^{-1}$ , and in the most preferred embodiments of the invention  
25 the shear rate is from about  $100 \text{ sec}^{-1}$  to about  $10,000 \text{ sec}^{-1}$ .

Any method which can be used to apply a shear to a flowable mixture or any polymer melt can be used. The shearing action can be provided by any appropriate  
30 method, as for example by mechanical means, by thermal shock, by pressure alteration, or by ultrasonics. Methods useful in shearing melts are known in the art, and will not be described in great detail. In particularly useful procedures, the flowable polymer  
35 mixture is sheared by mechanical methods in which portions of the melt are caused to flow past other portions of the mixture by use of mechanical means such

as stirrers, Banbury® type mixers, Brabender® type mixers, long continuous mixers, and extrudes. Another procedure employs thermal shock in which shearing is achieved by alternatively raising or lowering the temperature of the mixture causing thermal expansions and resulting in internal stresses which cause the shear. In still other procedures, shear is achieved by sudden pressure changes in pressure alteration methods; by ultrasonic techniques in which cavitation or resonant vibrations which cause portions of the mixture to vibrate or to be excited at different phases and thus subjected to shear. These methods of shearing flowable polymer mixtures and polymer melts are merely representative of useful methods, and any method known in the art for shearing flowable polymer mixtures and polymer melts may be used.

In the preferred embodiments of the invention, mechanical shearing methods are employed such as by extrusion, injection molding machines, Banbury® type mixers, Brabender® type mixers and the like. In the more preferred embodiments of the invention, shearing is achieved by introducing the polymer melt at one end of the extruder (single or double screw) and receiving the sheared polymer at the other end of the extruder. The temperature of the polymer melt, the length of the extruder, residence time of the melt in the extruder and the design of the extruder (single screw, twin screw, number of flights per unit length, channel depth, flight clearance, mixing zone etc.) are several variables which control the amount of shear to be applied.

Upon subjecting a flowable mixture of said swellable intercalated layered material and said polymer melt to shear mixing, at least about 80% by weight, preferably at least about 85% by weight, more preferably at least about 90% by weight and most preferably at least about 95% by weight of the layers

the material delaminate to form platelet particles substantially homogeneously dispersed in the polymer matrix. As used herein, "platelet particles" are particles having two relatively flat opposite faces wherein the thickness of which is the distance between the faces, which is relatively small compared to the size of the faces. As formed by this process, the platelet particles dispersed in matrix polymers have the thickness of the individual layers, or small multiples less than about 10, preferably less than about 5 and more preferably less than about 3 of the layers, and still more preferably 1 or 2 layers. In the preferred embodiments of this invention, intercalation of every interlayer space is complete so that all or substantially all individual layers delaminate one from the other to form separate platelet particles. In cases where intercalation is incomplete between some layers, those layers will not delaminate in the polymer melt, and will form platelet particles comprising those layers in a coplanar aggregate. These latter platelet particles still constitute nanoscale and nanodispersed fillers and provide enhanced properties over and above those provided by conventional micro-scale fillers, as long as they are less than about 10 layers thick and preferably less than 5 layers thick. The other dimensions of the platelet particles may vary greatly, but in the case of particles derived from clay minerals, the particle faces are roughly round or oblong having average diameters between about 10,000 Å and about 50 Å, such that the aspect ratio length/thickness ranges from about 1000 to about 1. For the purposes of the present invention, the average diameter is defined as the diameter of a circle having an area equal to the surface area of one broad surface face of the platelet shaped particle. The average diameter is determined from particle surface area as measured with a Litz

Textur Analyzer System in a fully computerized and automated mode. In the preferred embodiments of the invention the average thickness of the platelet particles is equal to or less than about 20 Å and the average diameter is between 5,000 Å and 100 Å. Most preferably the average thickness is about 10 Å. The most preferred average diameter depends on both the desired property of the nanocomposite and the ease of complete intercalation and delamination to form the nanocomposite structure. High aspect ratios, and therefore large average diameters, are generally preferred for reinforcement and barrier properties, while layered materials having smaller platelets are preferred for their ease of delamination. Thus, for purposes of the nanocomposite properties, the most preferred average diameter is greater than about 150 Å, and, for purposes of delamination, it is less than about 3000 Å.

The average interparticle spacing between delaminated layers may vary widely after shearings, depending on the concentration of layered material. In general the higher the concentration of layered material in the polymer matrix particle the smaller the interparticle spacing; and conversely, the lower the concentration of layered material, the larger the interparticle spacing. In general, interparticle spacing is equal to or greater than 15Å. The interparticle spacing is preferably equal to or greater than about 20Å more preferably equal to or greater than about 30Å and most preferably equal to or greater than about 50Å.

As used herein "uniformly dispersed" is defined as a degree of dispersion of the platelet shaped particles having a standard deviation in platelet particle density, down to a sampling volume of  $10^{-15} \text{m}^3$ , which is preferably less than about 50% of the mean, more preferably less than about 30% of the mean, and most

preferably less than about 20% of the mean as determined from estimates based on transmission electron microscopy.

The process of this invention is preferably carried out in the absence of air, as for example in the presence of an inert gas, such as, argon, neon, nitrogen or the like. The process can be carried out in a batchwise or discontinuous fashion, as for example, carrying out the process in a sealed container. Alternatively, the process can be carried out in a continuous fashion in a single processing zone, as for example by use of an extruder, from which air is largely excluded, or in a plurality of such reaction zones in series or parallel.

The nanocomposites of this invention exhibit useful properties which are superior to those predicted by U.S. Patent Nos. 4,739,007 and 5,810,734. Various useful performance indices can be devised in order to jointly assess different performance aspects using a single number. Depending upon the nature of the devised index, comparisons can be made either between samples containing the same loading of layered material or the index can be more broadly applied to polymers having different loadings of clay. For example, the effect of adding nanoscale particulate fillers dispersed platelet particles to a polymer typically increases tensile modulus and ultimate tensile strength while decreasing ultimate elongation. In the case where combinations of high modulus ( $Y$ ) and high ultimate elongation ( $\Delta L/L$ ) are required, a useful performance index for comparing samples with similar particulate loading is  $Y(\Delta L/L)$ . Likewise, when tensile strength ( $S$ ) combined with high ultimate elongation is sought, a useful performance index for comparing samples with similar loading levels is  $S(\Delta L/L)$ . The preferred embodiments of the present invention provide a  $Y(\Delta L/L)$  of above about 660 MPa (preferably equal to

r greater than about 800 MPa more preferably equal to or greater than about 1000 MPa and most preferably equal to or greater than about 1200 MPa) for a loading of about 2% of nanodispersed layered material such as montmorillonite in a melt processible polymer such as nylon 6. In contrast, the prior art patents on in-reactor nanocomposite blends (U.S. 4,739,007 and U.S. 4,810,734) provide a maximum  $\gamma(\Delta L/L)$  of about 660 MPa. Also, preferred embodiments of the present invention provide a  $S(\Delta L/L)$  of above about 20 MPa (preferably equal to or greater than about 25 MPa and more preferably equal to or greater than about 30 MPa) for a loading of about 2% intercalated layered material such as montmorillonite, while the maximum value for this figure of merit obtained in the above mentioned in-reactor process patents is about 20 MPa at 2% loading. While we do not wish to be bound by any theory, it is believed that the unique properties of the nanocomposites of this invention result from the use of swelling/compatibilizing agents which do not react to become part of the main chain of the matrix polymer (as do the swelling agents preferred in the prior art U.S. 4,739,007 and U.S. 4,810,734) when used in the in-reactor processes. Instead, the preferred swelling/compatibilizing agents of this invention, which remain bonded to the particle surface, interact with the matrix polymer in one or more of the following ways: (1) covalent bond formation to form branches on the main chains of the matrix polymer, (2) hydrogen, ion-dipole, and dipole-dipole bonding with portions of the matrix polymer, and (3) Van der Waals attraction and entanglement with the matrix polymer. Nanocomposites having particularly attractive combinations of modulus, tensile strength and ultimate elongation are formed using swelling/compatibilizing agents, under category (3) above, which are bonded to the particle surface, and whose polymer-interacting

moiety projects away from the particle surface and is only weakly bonded to the matrix polymer. This function is best performed by silane compounds and onium compounds (especially ammonium compounds) of the type having a lipophilic moiety such that the surface tension, at 20°C, of the derivatized particle is between about 55 and 15 dyne/cm, and preferably between 45 and 20 dyne/cm, as determined by measuring the contact angles made by sessile drops of liquids on the solid surfaces. Illustrative of these preferred silane compounds and onium are silanes of the formula; - $\text{Si}(\text{R}^9)_2\text{R}^8$  and ammonium cations of the formula: - $\text{NH}(\text{R}^{17})_2\text{R}^{18}$  and - $\text{N}(\text{R}^{17})_3\text{R}^{18}$  where  $\text{R}^9$  is the same or different at each occurrence and is alkyl, alkoxy or oxysilane;  $\text{R}^{17}$  is the same or different at each occurrence and is alkyl and  $\text{R}^{18}$  and  $\text{R}^8$  are the same or different and are organic groups which are compatible with the polymer. Preferably,  $\text{R}^{18}$  and  $\text{R}^8$  are groups such that the silane compound or ammonium radical on the particle has a surface tension at 20°C of less than about 55 dyne/cm. The surface tension of platelet particles derivatized with agents containing octadecane moieties is estimated to be about 31 to about 38 dyne/cm by analogy to poly(ethylene) and poly(propylene). In contrast, the surface tension of 11-aminoundecanoic acid is estimated to be about 59 dyne/cm by analogy to poly(ethylene-co-acrylic acid) (20 mole % acrylic acid) (Polymer Handbook, Third Edition, J. Brandrup and E.H. Immergut, eds. (Wiley, New York, 1989) pp. VI411).

The nanocomposite compositions according to the invention are thermoplastic and, in some cases, vulcanizable materials from which molded articles of manufacture having valuable properties can be produced by conventional shaping processes, such as melt spinning, casting, vacuum molding, sheet molding, injection molding and extruding. Examples of such



molded articles are components for technical equipment, apparatus castings, household equipment, sports equipment, bottles, containers, components for the electrical and electronics industries, car components, circuits, fibers, semi-finished products which can be shaped by machining and the like. The use of the materials for coating articles by means of powder coating processes is also possible, as is their use as hot-melt adhesives. The molding compositions according to the invention are outstandingly suitable for specific applications of all types since their spectrum of properties can be modified in the desired direction in manifold ways. Such molded products of this invention will derive one or more advantages over products molded with polymers having no nanodispersed platelet particles including increased modulus, stiffness, wet strength, dimensional stability, and heat deflection temperature, and decreased moisture absorption, flammability, permeability, and molding cycle time.

The molding compositions according to the invention are outstandingly suitable for the production of sheets and panels having valuable properties. Such sheets and panels may be shaped by conventional processes such as vacuum processing or by hot pressing to form useful objects. The sheets and panels according to the invention are also suitable as coating materials for other materials comprising, for example, wood, glass, ceramic, metal or other plastics, and outstanding strengths can be achieved using conventional adhesion promoters, for example, those based on vinyl resins. The sheets and panels can also be laminated with other plastic films and this is preferably effected by co-extrusion, the sheets being bonded in the molten state. The surfaces of the sheets and panels, including those in the embossed form, can be improved or finished by

conventional methods, for example by lacquering or by the application of protective films.

The compositions of this invention are specially useful for fabrication of extruded films and film laminates, as for example, films for use in food packaging. Such films can be fabricated using conventional film extrusion techniques. The films are preferably from about 10 to about 100 microns, more preferably from about 20 to about 100 microns and most preferably from about 25 to about 75 microns in thickness. In the film, the major plane of the platelet fillers is substantially parallel to the major plane of the film. The extent of parallelism of particles and film can be determined by X-ray analysis. X-ray analysis is a useful way to describe the crystallinity and orientation of polymer crystals and the orientation of platelet particles. A convenient method of X-ray analysis is that described in Hernans, P.H. and Weidinger A., Makromol Chemie, Vol. 44, pp. 24-36 (1961), hereby incorporated by reference.

For the purpose of the present invention  $O_p$ , the platelet orientation factor, is an indication of the platelet particle orientation in the film. The  $O_p$  was determined by making azimuthal scans from densitometer tracings of the X-ray photographs which were obtained by exposing the edge of the film to the incident X-rays. The angle is the angle between the reference direction, the normal to the film, and the normal to the plane of interest, the major plane of the platelet. The  $O_p$  values were calculated as the average cosine square ( $\langle \cos^2 \rangle$ ) for the normal to the flat faces of the platelet particles. An  $O_p$  of 1.0 indicates that the faces of the platelets are completely parallel to the plane of the film. An  $O_p$  of 0.0 indicates that the faces of the platelets are perpendicular to the plane of the film. The  $O_p$  of the platelets in the film of the present invention is preferably from about 0.70 to

about 1.0, more preferably from about 0.90 to about 1.0 and most preferably from about 0.95 to about 1.0. Such preferred orientation of platelet particles results in enhanced barrier properties and increased tare  
5 strength.

The homogeneously distributed platelet particles and polymer are formed into a film by suitable film-forming methods. Typically, the composition is melted and forced through a film forming die. The die can be  
10 a flat die or a circular die. A typical flat die is a hanger shaped die, and a typical circular die is a tubular film die.

The film of the nanocomposite of the present invention may go through steps to cause the platelets  
15 to be further oriented so the major planes through the platelets are substantially parallel to the major plane through the film. A method to do this is to biaxially stretch the film. For example, the film is stretched in the axial or machine direction by tension rollers  
20 pulling the film as it is extruded from the die. The film is simultaneously stretched in the transverse direction by clamping the edges of the film and drawing them apart. Alternatively, the film is stretched in the transverse direction by using a tubular film die  
25 and blowing the film up as it passes from the tubular film die. The films of this invention may exhibit one or more of the following benefits: increased modulus, wet strength, and dimensional stability, and decreased moisture adsorption and permeability to gases such as  
30 oxygen and liquids such as water, alcohols and other solvents.

The following specific examples are presented to more particularly illustrate the invention and are not to be construed as limitations thereon.

EXAMPLE 1

Three nylon 6/montmorillonite nanocomposites, each comprising about 2% by weight montmorillonite layers, were prepared by extruding nylon 6 along with powdered montmorillonite intercalated with cations derived from 11-aminoundecanoic acid (Mont-11), octadecylamine (Mont-18), and a tertiary alkylamine (in a commercial intercalated montmorillonite, Claytone APA™, obtained from Southern Clay Products). The octadecylamine-montmorillonite complex (Mont-18) was prepared by combining a water/ethanol solution of octadecylamine hydrochloride with a hot (60 to 80°C) aqueous dispersion of montmorillonite such that the ratio of ethanol to water in the dispersion was about 10% by volume. The stoichiometry of the mixture was 0.11 moles of amine per 100 g of mineral, or 1.1 equivalents of the mineral's ion exchange capacity. The octadecylamine hydrochloride solution was prepared by dissolving the amine in hot ethanol and combining this solution with hot water containing a 20% excess of hydrochloric acid. The aqueous dispersion of montmorillonite was prepared by stirring montmorillonite (Gelwhite HNF™, Southern Clay Products) into hot water (60-80°C) for 30 min using a homogenizer, adding 5 g of a peptizing agent (sodium hexametaphosphate) per 100 g of mineral, and separating out non-dispersible particles by sedimentation. The Mont-18 complex formed a precipitate which, after standing 16 h, was filtered, washed 5 times with hot water, dried in a fluid bed dryer, ball milled to 100 mesh, and rigorously dried in vacuum at 130°C in the presence of phosphorus pentoxide for 16 h. The 11-aminoundecanoic acid-montmorillonite complex was formed by a similar procedure. Claytone APA was dried in vacuum at 130°C prior to compounding.

The nanocomp site of the octadecylamine-montmorillonite complex (Mont 18) in nylon 6 was formed

by feeding a mixture of nylon 6 pellets and rigorously dried octadecylamine-montmorillonite complex into a twinscrew extruder (Leistritz) equipped with general purpose screws and a vacuum attached to the die for devolatilization of the melt. Extruder heaters and screw speed were adjusted to settings used for processing the homopolymer. The nylon 6 nanocomposites of the 11-aminoundecanoic acid-montmorillonite (Mont-11) and Claytone APA were formed using a similar procedure.

Films were formed from the nanocomposites by extrusion through a die. The films were evaluated for light transmission. The extrudate transmitted light without haze or distortion.

The nanocomposite extrudates was dried and injection molded into test bars and the tensile strength and tensile modulus determined by the procedure of ASTM D638. The tensile strength and tensile modulus of the nylon was also evaluated for comparison purposes. The results are set forth Table 1. Tensile bars of nylon 6 homopolymer and each of the nanocomposites were immersed in water at 20°C for 14 days and their tensile properties evaluated. These results are set forth in the following Table 2.

25

**TABLE 1**

5	TENSILE PROPERTIES OF NYLON 6/MONTMORILLONITE NANOCOMPOSITES DRY AS MOLDED				
	Composite	Tensile Strength, psi (MPa)	Tensile Modulus, psi (MPa)	Elongation %	M <sub>v</sub> <sup>b</sup>
	Nylon 6	11,000 (76)	366,000 (2,530)	>200%	38,4 00
	1.6% montmorillonite (aminoundecanoic acid)	13,300 (92)	415,000 (2,870)	5%	35,9 00
	1.7% montmorillonite (- octadecylamine)	13,200 (91)	440,000 (3,040)	25%	37,6 00
10					
15	2.0% montmorillonite (Claytone APA)	13,300 (92)	544,000 (3,760)	36%	37,4 00
a. percentage is weight % mineral in the composite as determined from the ash content.					
20	b. based on formic acid viscosities corrected for the contribution of the dispersed silicates to the measured viscosities.				

**TABLE 2**

TENSILE PROPERTIES OF NYLON 6/MONTMORILLONITE COMPOSITES (1/8" TENSILE BARS) TESTED AFTER 14 DAYS IN WATER AT 20c			
Composite	Tensile Strength, psi (MPa)	Tensile Modulus, psi (MPa)	Elongation %
Nylon 6	4,200 (76)	113,000 (780)	>100%
1.6% montmorillonite (-aminoundecanoic acid)	6,000 (41)	185,000 (1,280)	60%
1.7% montmorillonite (-octadecylamine)	6,200 (43)	206,000 (1,420)	>100%
2.0% montmorillonite (Claytone APA)	6,200 (43)	220,000 (1,520)	>100%

Both dry-as-molded and water-soaked nanocomposite tensile test bars exhibited tensile strength and modulus superior to those of the extruded nylon. Table 1 shows that the average elongation-at-break of the two alkylammonium cation-intercalated montmorillonite nanocomposites, those with montmorillonite intercalated with octadecylammonium cation and the quaternary ammonium cation used in Claytone APA were superior to a comparable nanocomposite of 11-aminoundecanoic acid-montmorillonite complex.

**EXAMPLE 2**

A series of experiments were carried out to evaluate the effect of varying the concentration of intercalated montmorillonite (intercalated with 11-aminoundecanoic acid cation, Mont-11) on the properties of the nylon 6 nanocomposites. In these experiments, a series of nylon 6/Mont-11 nanocomposites, comprising montmorillonite layers in amounts ranging from 0.26% to 8.1% by weight, were prepared by extruding nylon-6 pellets along with powdered Mont-11. Comparison samples of homopolymer and a 9.3% composite of untreated montmorillonite were extruded as well. The Mont-11 complex was prepared and processed according to

the procedures described in Example 1, except for the following changes. An aqueous solution of 11-aminoundecanoic acid hydrochloride was combined with a 2% dispersion of montmorillonite. The more highly loaded composites (the 8.1% nanocomposite and the 9.3% composite of untreated montmorillonite) were prepared by adding an appropriate amount of the mineral component downstream in the extruder into already melted polymer. All samples were injection molded into test bars. The flexural strength and flexural modulus of the samples were evaluated by the procedures of ASTM D790, and their heat deflection temperatures, under 264 psi of load (DTUL 264), were evaluated by the procedures of ASTM D648. The results are set forth in Table 3.

TABLE 3

Composition	Flexural Strength, psi (MPa)	Flexural Modulus, psi (MPa)	Deflection Temperature at 264 psi (C)
nylon 6	15,500 (107)	385,000 (2,660)	55.6
0.27% silicate <sup>a</sup>	15,700 (108)	426,000 (2,940)	58.4
0.89% silicate	19,000 (131)	437,000 (3,020)	60.0
4.12% silicate	19,200 (133)	620,000 (4,280)	109.3
8.10% silicate	19,600 (135)	650,000 (4,490)	127.4
9.25% clay, unintercalated <sup>b</sup>	19,000 (131)	496,700 (3430)	59.2

a. montmorillonite intercalated by 11-aminoundecanoic acid cation (dispersible in polymer melt).

b. montmorillonite intercalated by Na<sup>+</sup> cation (non-dispersible in polymer melt).

As shown in Table 2, test bars of the nanocomposites exhibited enhanced flexural modulus over the homopolymer at loadings as low as 0.26% and enhanced flexural strength at loadings as low as 0.89%.



Using dynamic mechanical analysis, the effect of temperature on the elastic modulus of the nanocomposites was evaluated. The results are set forth in FIGS 1 and 2. As shown in FIG 1, the various nanocomposites showed comparable enhancements in their elastic modulus values at room temperature, but this enhancement increased substantially at temperatures above the glass transition temperature  $T_g$  (ca. 75°C). The composite of untreated montmorillonite exhibited greater strength and stiffness than the homopolymer, but not as great as the comparably loaded nanocomposite. As shown in FIG 2, the difference in elastic modulus values between the comparably loaded composites is particularly great at temperature above the  $T_g$ .

The average polymer molecular weight of in the nanocomposites declined with increased loading of the aminoundecanoic acid-montmorillonite complex, presumably due to chain scission reactions between the polyamide and the complex. Reactions with water or amines desorbed from the complex appeared to be, at most, a minor contributor to chain scission, since thermogravimetric analysis of the complex indicated no significant weight loss up to the melt processing temperature (ca. 260°C) that might be attributed to these species. By elimination, reaction with the carboxylic acid portion of the 11-aminoundecanoic acid cation appeared to be the most likely contributor to chain scission. In this case, omega-amino acids appear to be not preferred for use in melt processing mineral complexes with condensation polymers such as polyamides, polyesters, polycarbonates, and the like.

Films of nylon 6/Mont-11 nanocomposites were compression molded and evaluated for their water vapor and oxygen transmissions rates at both 0% and 100% relative humidity, using the procedures of ASTM D3985. The results are set forth in the following table 4.

**Table 4**  
**GAS TRANSMISSION RATES**

5	Composition	WVTR <sup>a</sup>	OTR <sup>b</sup> at 0% Relative Humidity	OTR <sup>b</sup> at 100% Relative Humidity <sup>b</sup>
	nylon 6	20	3.0	14.3
	0.47% silicate	-	-	11.0
10	1.55% silicate	-	-	8.1
	4.12% silicate	4	0.78	7.5

a. water vapor transmission rate (g-mil/100in<sup>2</sup>/day)

15

b. oxygen transmission rate (cc-mil/100in<sup>2</sup>/day)

As shown in Table 4, relative to nylon 6, the water vapor transmission rate decreased by a factor of 5 and the oxygen transmission rate (at 0% relative humidity) decreased by a factor of about 4 in films having about 4% by weight platelet particles dispersed in the nylon and oriented by the molding process with the planes of the particles substantially parallel with the plane of the film. Under the plasticizing influence of 100% relative humidity, the oxygen transmission rate was decreased by a factor of 1.8 at 1.55 weight % particles, and by a factor of 1.9 at 4.12 weight % particles.

30

### EXAMPLE 3

A series of experiments were carried out to compare various properties of nanocomposites formed by melt blending and by in-reactor compounding. Two comparable nanocomposites of nylon 6 were prepared: one by melt processing, and the other by in-reactor compounding. Both were injection molded into test bars which were characterized dry-as-mold d.

The former, a 4.1% Bent nit nan composite, was formed by extruding powdered Bentonite intercalated with 11-aminoundecanoic acid cation with nylon 6 pellets on a

single screw Killion extruder. The complex was prepared as described in Example 2.

The latter, a 4.5% bentonite nanocomposite, was prepared by polymerizing caprolactam in the presence of the bentonite-11-aminoundecanoic acid complex and aminocaproic acid (1%, by weight). The reaction mixture was stirred at 255°C in a steel resin kettle equipped with an "anchor" type stirrer. After 2.5 h, the polymerization mixture was cooled, ground into particles (ca. 2 mm in diameter), and washed 3 times, for 1 h each time, in boiling water. The washed composite was dried, extruded and pelletized, and redried.

The two nanocomposites were qualitatively the same in most respects: x-ray diffraction (XRD) patterns, infrared (IR) spectra, melting and crystallization temperatures (DSC), optical microscopy, transmission electron microscopy (TEM), and mechanical properties. Analysis of the XRD patterns indicated that both composites were about 50% crystalline, had crystallite coherence lengths of 70Å to 80Å. This crystalline portion was 80% to 90% in the gamma phase of nylon 6. IR confirmed the predominance of gamma phase and indicated a higher concentration of silicate in the in-reactor composite. Optical microscopy showed that, in both composites, large spherulites were prevented from forming. TEM's of each composites showed parallel streaks (presumed to be edge views of the layers) that were less than 200Å thick and 3000Å to 15000Å long. The TEM of the extruder-formed nanocomposite is shown in FIG 3. The tensile modulus, yield strength, and heat deflection temperature under load (DTUL 264 psi) were determined by the procedures of ASTM D638 and D648, respectively. The results are set forth in Table 5.

**TABLE 5**

NYLON 6/BENTONITE NANOCOMPOSITES BY MELT MIXING and MONOMER BLENDING AND POLYMERIZING PROCESSES (dry as molded)			
Composition	Tensile Modulus, psi (MPa)	Yield Strength <sup>a</sup> , psi (MPa)	DTUL <sup>b</sup> @ 264 psi (C)
Nylon 6	380,000 (2,630)	10,300 (71)	57
melt-mixed <sup>c</sup> Nylon 6/ bentonite 4.1% silicate	610,000 (4,210)	13,400 (93)	109
in-reactor nylon 6/bentonite 4.5% silicate	580,000 (4,010)	13,400 (93)	129
a. composites broke at or before yield; elongation was ca. 10%.			
b. heat deflection temperature under load.			
c. single screw extruder.			

The results show that the tensile modulus and yield strength values of the two composites were nearly identical, while the heat deflection temperature of the in-reactor composite was 20°C higher. We speculate that the difference in DTUL values reflected less complete exfoliation and dispersion in the polymer melt-mixed nanocomposite.

**Example 4**

Nanocomposites of the mont-11 complex were prepared by extrusion with nylon 10-10, nylon 6,6-6 (6:4), and an amorphous polyamide, nylon 6,6-6,6-10. The compositions were fabricated into test bars and the flexural strength, flexural modulus and elongation-to-break were evaluated as described in Example 1. The results set forth in Tables 6, 7 and 8. In each case, the composite exhibited enhanced mechanicals over the homopolymer.

**TABLE 6**

Composition	Flexural Strength, psi (MPa)	Flexural Modulus, psi (MPa)	elongation at break (%)
Nylon 10,10	9,200 (64)	290,500 (2,010)	250
2% montmorillonite <sup>a</sup>	11,000 (76)	370,500 (2,560)	20

**Table 7**

Composition	Flexural Strength, psi (MPa)	Flexural Modulus, psi (MPa)	Elongation at break (%)
Nylon 6,66	14,000 (97)	330,000 (2,280)	230
2% montmorillonite <sup>a</sup>	16,500 (114)	400,000 (2,760)	>80
(a) Treated with 11' aminoundecanoic acid HCl			

**Table 8**

Composition	Tensile Strength (psi) (MPa)	Tensile Modulus (psi) (MPa)	Elongation at Break %
Nylon 6,6-6,6-10	5,700 (39)	205,000 (1,420)	>200
1% montmorillonite <sup>a</sup>	6,800 (47)	275,000 (1,900)	>200
a. Treated with 11-aminoundecanoic acid HCl.			

**EXAMPLE 5**

A molding grade of nylon 6 (Grade 8202 obtained from Allied-Signal) was compounded with montmorillonite intercalated with octadecylammonium cation as described in Example 1. It was also compounded with two different loading of silanized wollastonite particles for purposes of comparison. 96% of the wollastonite, a needle-like mineral, was comprised of particles of less than 10 microns in length, and it was silanized with aminopropyl trimethoxysilane. The composites were injection molded into test samples and evaluated for their flexural properties and heat deflection temperatures under 264 psi of load. The results are set forth in Table 9.

**TABLE 9**

Composition	Flexural Modulus, psi (MPa)	Flexural Strength, psi (MPa)	DTUL 264 psi (C)
8% wollastonite <sup>a</sup>	464,000 (3,210)	18,100 (125)	59.2
16% wollastonite <sup>a</sup>	515,700 (3,560)	19,800 (137)	68.7
6% dispersed silicate <sup>b</sup>	630,000 (4,350)	21,100 (146)	126.9

a. silanized with aminopropyltrimethoxysilane.

b. from montmorillonite intercalated with octadecylammonium cation, Mont-18.

**EXAMPLE 6**

Two nanocomposites of non-polyamides were formed by feeding a mixture of intercalated montmorillonite and

polymer pellets into a twinscrew extruder. One composite was polyethyleneterephthalate, PET, having 0.36% mineral derived from Claytone APA. The other was polypropylene having 0.14% mineral derived from Mont-18. Both composites were injection molded into test samples and evaluated for their tensile properties. The results are set forth in Tables 10 and 11. Both composites exhibited increases in stiffness and strength over their homopolymers, even at these low loadings.

TABLE 10

Composition	Tensile Modulus, psi (MPa)	Yield Strength, psi (MPa)
PET <sup>a</sup>	270,000 (1,870)	7,900 (55)
PET/0.38% montmorillonite <sup>b</sup>	314,000 (2,170)	8,100 (56)

a. poly(ethylene terephthalate)

b. derived from montmorillonite intercalated with octadecylammonium cation

TABLE 11

Composition	Tensile Modulus, psi (MPa)	Yield Strength, psi (MPa)
polypropylene	220,000 (1,520)	4,900 (34)
polypropylene/0.14% montmorillonite <sup>a</sup>	243,000 (1,680)	5,200 (36)

a. derived from Claytone APA.

**EXAMPLE 7**

Nanocomposites of montmorillonite, derivatized with silanes, and nylon 6 were formed by extruding nylon pellets along with silane derivatized montmorillonite following the procedure of Example 1. Silane-derivatized montmorillonite was prepared by adding the silane to a dispersion of Claytone APA in refluxing dioxane (100 g Claytone per 1000 mL dioxane) in a ratio of 70 mmole of silane per 100 g of silicate in the Claytone. The

derivatized silicate was separated by filtration from the dioxane and then displaced amine species. The silanes used were aminoethylaminopropyl(trimethoxy)silane and trimethoxysilyloctadecane. The tensile modulus, yield strength, and ultimate elongation of the nanocomposites were determined by the procedures of ASTM D638. The results are set forth in the following Table 12.

**TABLE 12**

Composition	Tensile Modulus psi (MPa)	Tensile Strength psi (MPa)	Elongation at Break (%)
nylon <sup>6</sup> control	422,700 (2,920)	11,000 (76)	36
2.66 % silicate aminoalkylsilane	530,400 (3,660)	12,100 (83)	10
1.05 % silicate octadecylsilane	559,300 (3,860)	12,600 (87)	45

The combination of tensile properties exhibited by the composite of octadecylsilane-derivatized silicate compares favorably with that of similarly loaded nanocomposites of montmorillonite derivatized by 11-ammoniumundecanoic acid cation, octadecylammonium cation, and the quaternary ammonium cation in Claytone, as shown in Table 1. In addition, it unexpectedly exhibits an increase in elongation compared to the homopolymer as well as the reinforcement characteristic of the nanocomposites.

**EXAMPLE 8**

Nanocomposites of montmorillonite, derivatized by a silane coupling agent, with polypropylene are prepared by treating mont-18 with vinyltris(t-butylperoxy)silane (3.2 g silane per 123 g mont-18), drying the resulting compound at 130°C for 6 h, and compounding the resulting powder with polypropylene melt in an extruder. The resulting nanocomposite exhibits enhanced mechanical



properties over nanocomposites having no silane treatment.

EXAMPLE 9

A nanocomposite of montmorillonite and nylon 6,  
5 having 5.14% silicate by weight and having a particularly  
high modulus, was formed by extruding Claytone APA with  
nylon 6 pellets following the procedure in Example 1.  
The tensile modulus was 727,000 psi (5,020 MPa) which  
constituted a 72% increase over that of the homopolymer  
10 (422,700 psi(2,920 MPa)).

**WHAT IS CLAIMED IS:**

1. Composite material comprising a melt processible polymer matrix and dispersed platelet particles having average thicknesses less than 50 Å, and having chemical species bonded to them, said chemical species having a moiety which projects away from the particle surface and which is not covalently bonded to the polymer matrix, said platelet particles being present in an amount less than about 60% by weight of the composite material wherein the chemical species is selected from the group consisting of chemical species comprising a silane function or onium cation function and having a group which is compatible with the matrix polymer.

2. Composite material as defined in claim 1, wherein the chemical species is selected from silanes of the formula:  $(-\text{Si}(\text{R}^9)_2\text{R}^8)$  and ammonium cations of the formula:  $(-\text{NH}_2\text{R}^{18})$ ,  $(-\text{NH}_2\text{R}^{17}\text{R}^{18})$ ,  $(-\text{NH}(\text{R}^{17})_2\text{R}^{18})$  and  $(-\text{N}(\text{R}^{17})_3\text{R}^{18})$ , where  $\text{R}^9$  is the same or different at each occurrence and is alkyl, alkoxy, or oxysilane,  $\text{R}^{17}$  is the same or different at each occurrence and is alkyl, and  $\text{R}^8$  and  $\text{R}^{18}$  are the same or different and groups which are compatible with the matrix polymer.

3. Composite material as defined in claim 1, wherein said matrix polymer is a thermoplastic polymer selected from the group consisting of polyamides, polyesters, polycarbonates, celluloses, phenolics, poly(urethanes), poly(sulfones), poly(etheretherketones), poly(esteramides), poly(phenylenesulfides), poly(amideimides), polyacetals, poly(alkylene oxides), poly(phenylene oxides), poly(imides) and polymers formed by the polymerization of alpha, beta-unsaturated monomers of the formula:  $\text{R}^{15}\text{R}^{16}-\text{C}=\text{CH}_2$ , wherein  $\text{R}^{15}$  and  $\text{R}^{16}$  are the same or different and are hydrogen, hydroxy, halo, alkylcarbonyl, carboxy, alkoxycarbonyl, heterocycle, alkyl or aryl either unsubstituted or substituted with one or more substituents selected from the group consisting of alkoxy, cyano, hydroxy, alkyl, and aryl.

4. Composite material as defined in claim 2, where in  
 $R^8$  and  $R^{18}$  are the same or different and are moieties  
 selected from a group consisting of alkyl, cycloalkenyl,  
 cycloalkyl, aryl, or alkylaryl, either unsubstituted or  
 5 substituted with amino, alkylamino, dialkylamino, nitro,  
 azido, alkenyl, alkoxy, cycloalkyl, cycloalkenyl,  
 alkanoyl, alkylthio, alkyl, aryloxy, arylalkylamino,  
 alkylamino, arylamino, dialkylamino, diarylamino, aryl,  
 alkylsulfinyl, aryloxy, alkylsulfinyl, alkylsulfonyl,  
 10 arylthio, arylsulfinyl, alkoxycarbonyl, arylsulfonyl,  
 alkylsilane, and a moiety of the formula:



wherein  $R^6$  is alkyl, cycloalkyl, aryl,  $R'$  is hydrogen,  
 alkyl, or aryl, and  $Z$  is  $-O-$  or  $-NR^7-$ , where  $R^7$  is  
 15 hydrogen, alkyl, aryl, or alkylsilane.

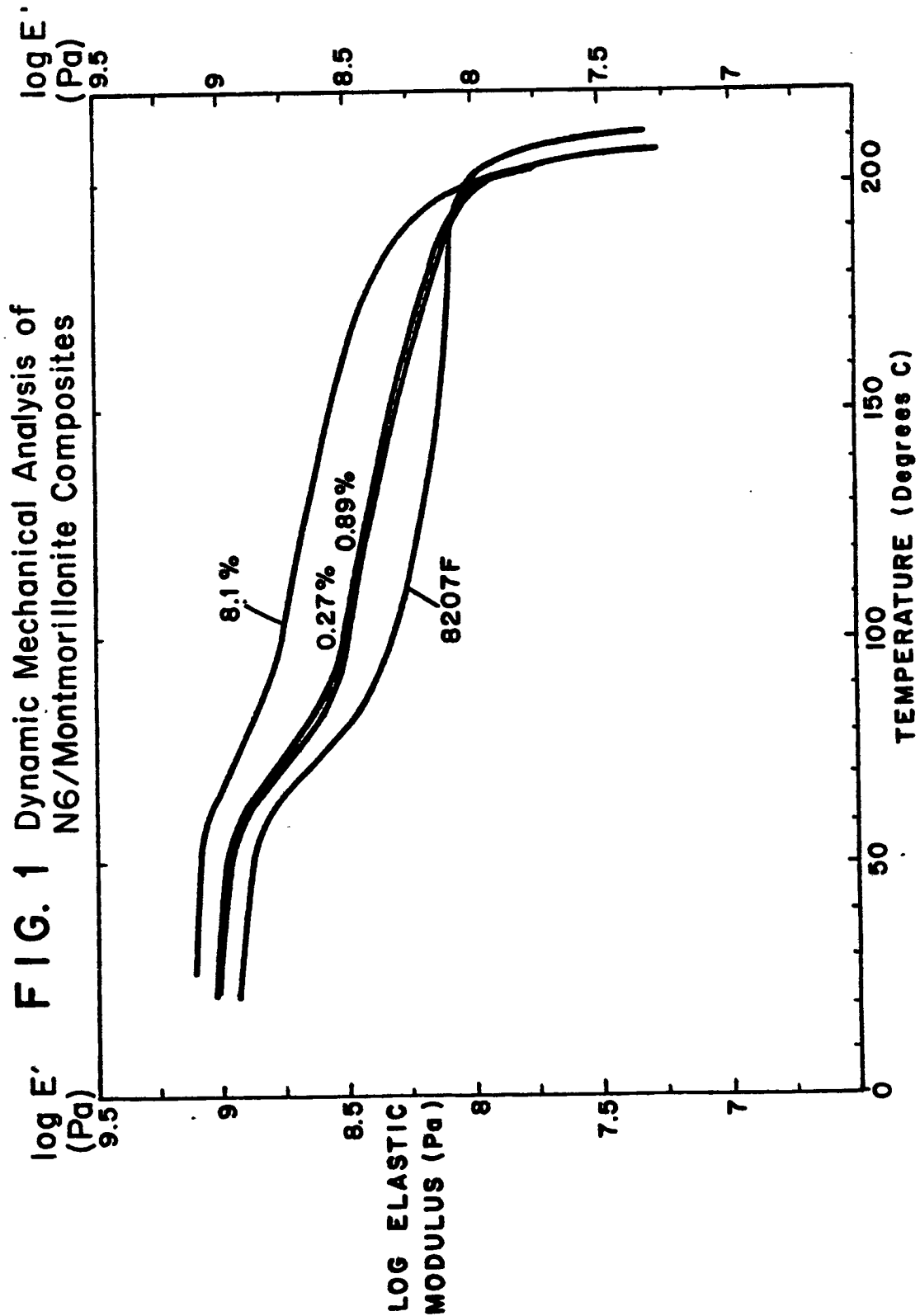
5. Composite material of claim 1 wherein said  
 platelet particle is less than 50 Å thick.

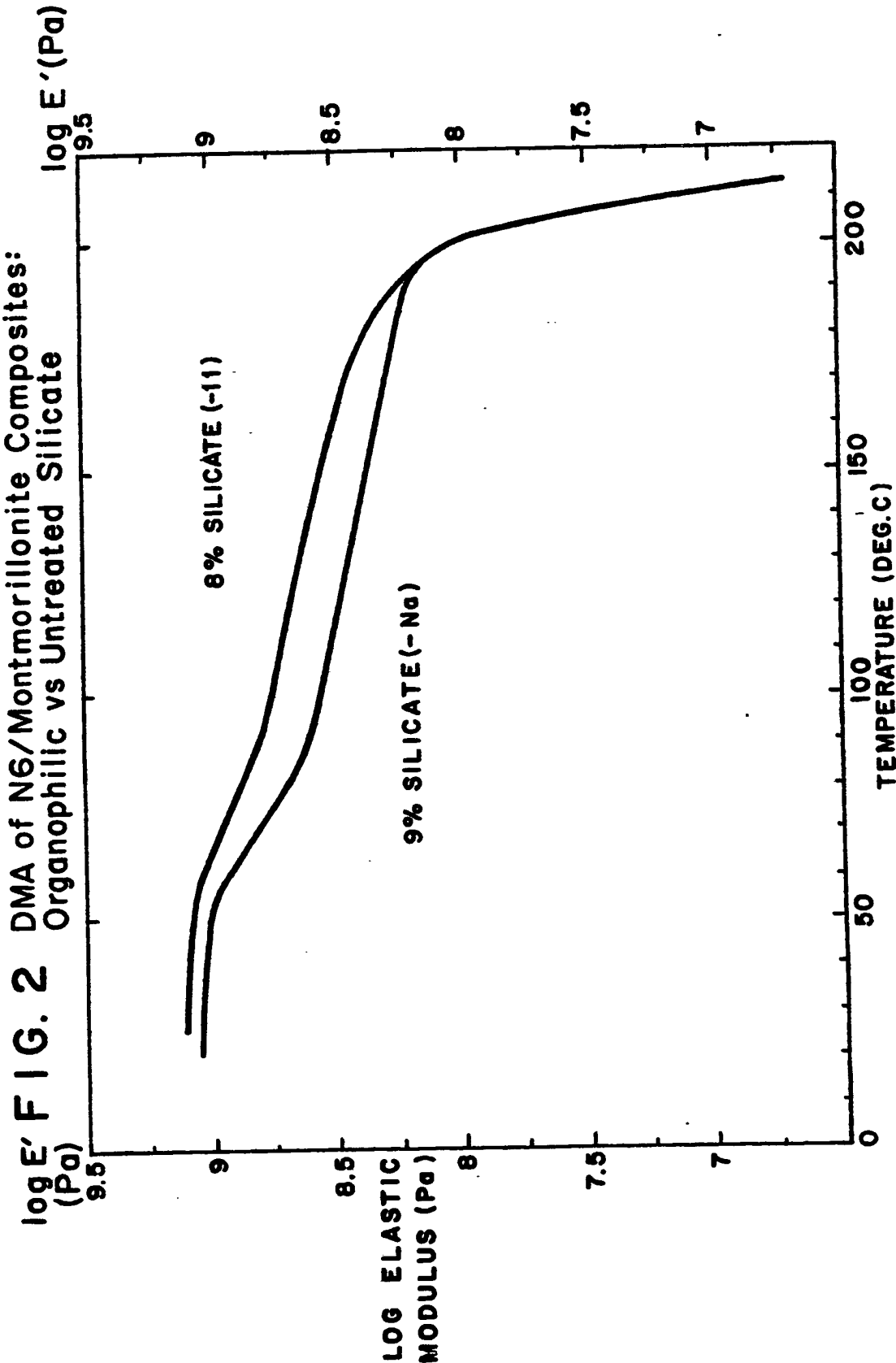
6. Composite material of claim 5, wherein said  
 platelet particle is between 20 Å and 7 Å in thickness.

20 7. Composite material of claim 1 wherein the  
 interparticle spacing between platelet particles is  
 greater than about 15 Å.

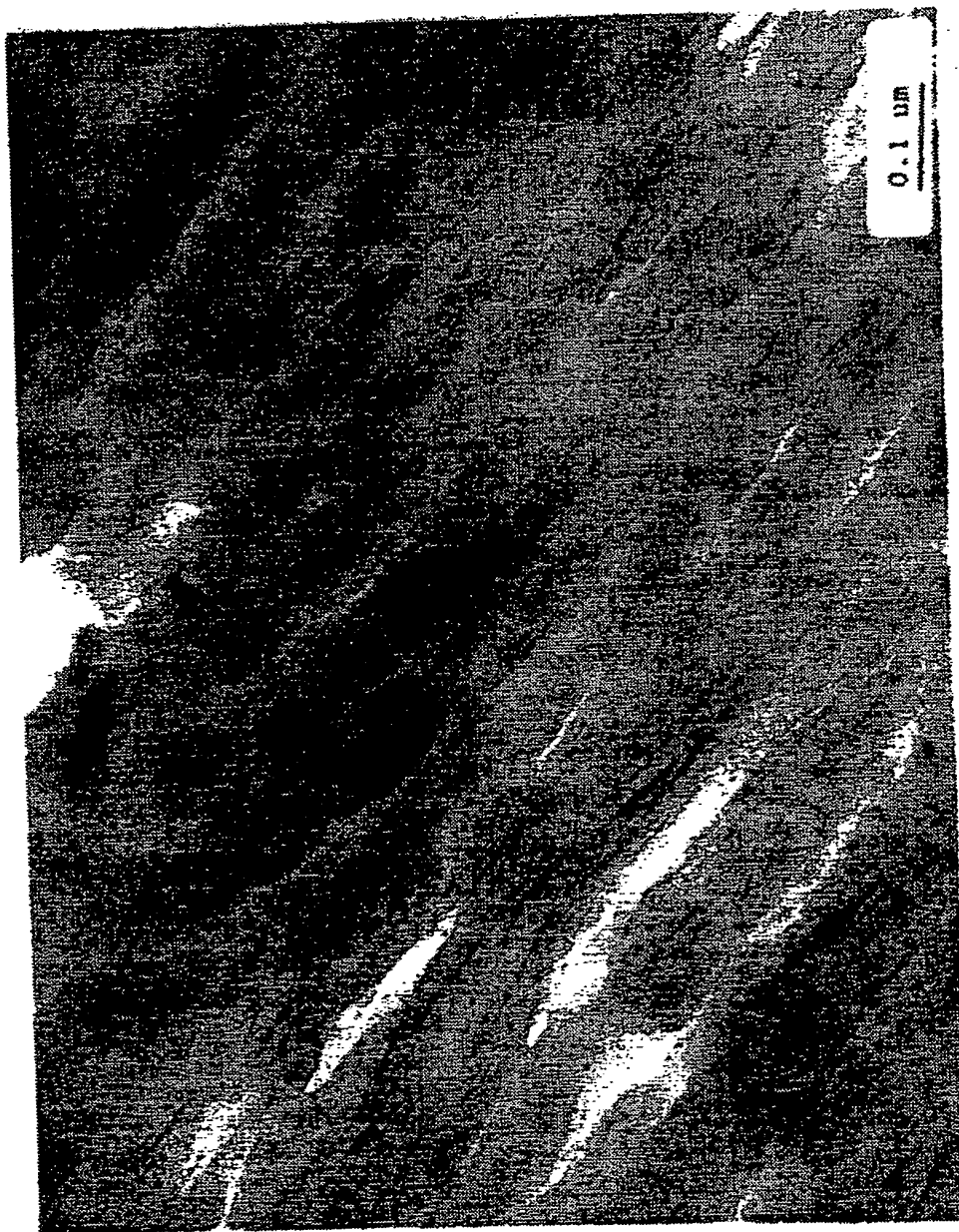
8. Composite material of claim 1 wherein said  
 platelet particle is a phyllosilicate.

25 9. An article of manufacture comprising a body, said  
 body fabricated, totally or in part, from a composite  
 material comprising a melt processible polymer matrix and  
 dispersed platelet particles having average thicknesses  
 less than 50 Å and a maximum thickness of 100 Å, and  
 30 having chemical species bonded to them, said chemical  
 species having a moiety which projects away from the  
 particle surface and which is not covalently bonded to  
 the polymer matrix, said platelet particles being present  
 in an amount less than about 60% by weight of the  
 35 composite material.





**FIGURE 3**  
**4% MONTMORILLONITE in NYLON**



# INTERNATIONAL SEARCH REPORT

PCT/US 92/06733

International Application No

<b>I. CLASSIFICATION F SUBJECT MATTER</b> (If several classification symbols apply, indicate all) <sup>6</sup> According to International Patent Classification (IPC) or to both National Classification and IPC Int.Cl. 5 C08K9/04; C08K9/06		
<b>II. FIELDS SEARCHED</b> Minimum Documentation Searched <sup>7</sup> Classification System Int.Cl. 5 C08K Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched <sup>8</sup>		
<b>III. DOCUMENTS CONSIDERED TO BE RELEVANT<sup>9</sup></b>		
Category <sup>10</sup>	Citation of Document, <sup>11</sup> with indication, where appropriate, of the relevant passages <sup>12</sup>	Relevant to Claim No. <sup>13</sup>
X	EP,A,0 398 551 (UBE INDUSTRIES, LTD.) 22 November 1990 see claims; examples 1,2	1-6,8,9
X	EP,A,0 276 915 (IMPERIAL CHEMICAL INDUSTRIES PLC) 3 August 1988 see claims; examples	1-6,8,9
X	GB,A,2 048 285 (GENERAL ELECTRIC COMPANY) 10 December 1980 see page 2, line 29 - line 32; claims 1,10,11; examples 1-4	1-4,8,9
<p><sup>10</sup> Special categories of cited documents:</p> <p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.</p> <p>"A" document member of the same patent family</p>		
<b>IV. CERTIFICATION</b>		
Date of the Actual Completion of the International Search 30 NOVEMBER 1992		Date of Mailing of this International Search Report - 8. 12. 92
International Searching Authority EUROPEAN PATENT OFFICE		Signature of Authorized Officer FUHR C.K.B.

# ANNEX TO THE INTERNATIONAL SEARCH REPORT ON INTERNATIONAL PATENT APPLICATION NO. US 9206733 SA 63807

This annex lists the patent family members relating to the patent documents cited in the above-mentioned international search report.  
The members are as contained in the European Patent Office EDP file on  
The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information. 30/11/92

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
EP-A-0398551	22-11-90	JP-A- 2305828	19-12-90
		US-A- 5102948	07-04-92
EP-A-0276915	03-08-88	AU-B- 612338	11-07-91
		AU-A- 1035488	21-07-88
		JP-A- 63199758	18-08-88
		ZA-A- 8800258	18-07-88
GB-A-2048285	10-12-80	GB-A, B 2123014	25-01-84

EPO FORM P0079

For more details about this annex : see Official Journal of the European Patent Office, No. 12/82



# PCT

## INTERNATIONAL SEARCH REPORT

(PCT Article 18 and Rules 43 and 44)

Applicant's or agent's file reference <b>MAGNA381PCT</b>	<b>FOR FURTHER ACTION</b> see Notification of Transmittal of International Search Report (Form PCT/ISA/220) as well as, where applicable, Item 5 below.	
International application No. <b>PCT/US 99/ 29992</b>	International filing date (day/month/year) <b>17/12/1999</b>	(Earliest) Priority Date (day/month/year) <b>21/12/1998</b>
Applicant <b>MAGNA INTERNATIONAL OF AMERICA, INC. et al.</b>		

This International Search Report has been prepared by this International Searching Authority and is transmitted to the applicant according to Article 18. A copy is being transmitted to the International Bureau.

This International Search Report consists of a total of 3 sheets.

☒ It is also accompanied by a copy of each prior art document cited in this report.

### 1. Basis of the report

- a. With regard to the language, the international search was carried out on the basis of the international application in the language in which it was filed, unless otherwise indicated under this item.

☐ the international search was carried out on the basis of a translation of the international application furnished to this Authority (Rule 23.1(b)).

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2. ☐ Certain claims were found unsearchable (See Box I).

3. ☐ Unity of invention is lacking (see Box II).

### 4. With regard to the title,

☒ the text is approved as submitted by the applicant.

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### 5. With regard to the abstract,

☒ the text is approved as submitted by the applicant.

☐ the text has been established, according to Rule 38.2(b), by this Authority as it appears in Box III. The applicant may, within one month from the date of mailing of this international search report, submit comments to this Authority.

### 6. The figure of the drawings to be published with the abstract is Figure No.

☐ as suggested by the applicant.

☒ because the applicant failed to suggest a figure.

☐ because this figure better characterizes the invention.

5

☐ None of the figures.

# INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 99/29992

**A. CLASSIFICATION OF SUBJECT MATTER**  
 IPC 7 B29C67/00 C08K3/34

According to International Patent Classification (IPC) or to both national classification and IPC

**B. FIELDS SEARCHED**

Minimum documentation searched (classification system followed by classification symbols)  
 IPC 7 B29C C08K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

**C. DOCUMENTS CONSIDERED TO BE RELEVANT**

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 4 739 007 A (OKADA AKANE ET AL) 19 April 1988 (1988-04-19) cited in the application abstract	1,6
Y	column 3, line 30 column 3, line 42 - line 48	2-5,7-10
Y	US 4 572 856 A (GEMBINski JOHN C) 25 February 1986 (1986-02-25) the whole document	2-5,7-10
X	US 5 747 560 A (MAXFIELD MACRAE ET AL) 5 May 1998 (1998-05-05) column 6, line 60 -column 24, line 49 -/--	1,6

☒ Further documents are listed in the continuation of box C.

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Date of the actual completion of the international search

18 April 2000

Date of mailing of the international search report

28/04/2000

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# INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 99/29992

## C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
P,X	WO 99 61236 A (MAGNA INTERNATIONAL OF AMERICA ;WILSON PHILLIP S (US)) 2 December 1999 (1999-12-02) the whole document ----	1-10
P,X	WO 99 61237 A (MAGNA INTERNATIONAL OF AMERICA ;WILSON PHILLIP S (US)) 2 December 1999 (1999-12-02) the whole document ----	1-10
P,X	WO 99 61281 A (MAGNA INTERNATIONAL OF AMERICA ;WILSON PHILLIP S (US)) 2 December 1999 (1999-12-02) the whole document ----	1-10
P,X	WO 99 61287 A (MAGNA INTERNATIONAL OF AMERICA ;WILSON PHILLIP S (US)) 2 December 1999 (1999-12-02) the whole document ----	1-10
A	DE 196 25 797 A (VOLKSWAGENWERK AG) 9 January 1997 (1997-01-09) column 2, line 48 -column 4, line 4; claim 1 -----	1,6

# INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/US 99/29992

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WO 9961287	A	02-12-1999	NONE	
DE 19625797	A	09-01-1997	NONE	



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A1

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(71) Applicant (for all designated States except US): MAGNA INTERNATIONAL OF AMERICA, INC. [US/US]; 600 Wilshire Drive, Troy, MI 48084 (US).

(72) Inventor; and

(75) Inventor/Applicant (for US only): WILSON, Phillip, S. [US/US]; 5480 Huron Hill Drive, Commerce Township, MI 48382 (US).

(74) Agents: BARUFKA, Jack, S. et al.; Pillsbury Madison &amp; Sutro LLP, 1100 New York Avenue, N.W., Washington, DC 20005 (US).

(81) Designated States: AE, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CR, CU, CZ, DE, DK, DM, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).

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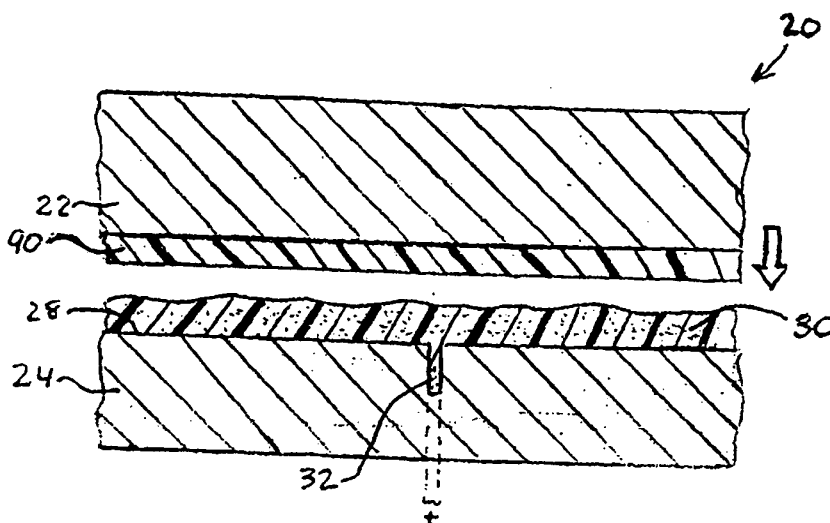
With international search report.

Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.

(54) Title: LOW PRESSURE COMPRESSION MOLDED PARTS HAVING NANO-PARTICLE REINFORCED PROTRUSIONS AND METHOD OF MAKING THE SAME

## (57) Abstract

A reinforced molded article having reinforced protrusions extending from the surface of the article is suitable for molding into automobile trim. The article comprises at least one thermoplastic; about 2 % to about 15 % by volume reinforcing particles having one or more layers of 0.7 nm-1.2 nm thick platelets, wherein more than about 50 % of the reinforcing particles are less than about 20 layers thick; whereby the reinforcing particles reinforce a protrusion from the surface of the molded article, the protrusion having a thickness of less than 1/10 inch. A method of producing reinforced articles comprising this reinforced protrusion is also disclosed.



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[US/US]; 5480 Huron Hill Drive, Commerce Township, MI  
48382 (US).

(21) International Application Number: PCT/US99/29992

(74) Agents: BARUFKA, Jack, S. et al.; Pillsbury Madison &  
Sutro LLP, 1100 New York Avenue, N.W., Washington, DC  
20005 (US).

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DM, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL,  
IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU,  
LV, MA, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT,  
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(AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU,  
MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM,  
GA, GN, GW, ML, MR, NE, SN, TD, TG).

(71) Applicant (*for all designated States except US*): MAGNA  
INTERNATIONAL OF AMERICA, INC. [US/US]; 600  
Wilshire Drive, Troy, MI 48084 (US).

(72) Inventor; and

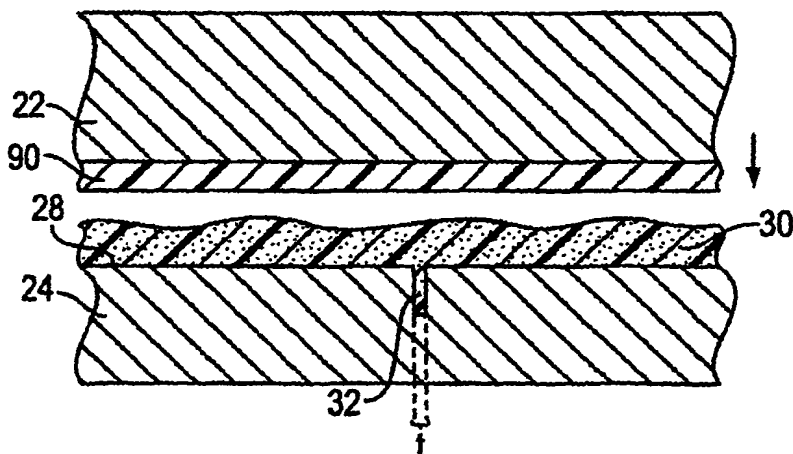
Published:

(75) Inventor/Applicant (*for US only*): WILSON, Phillip, S.

— with international search report

[Continued on next page]

(54) Title: LOW PRESSURE COMPRESSION MOLDED PARTS HAVING NANO-PARTICLE REINFORCED PROTRUSIONS  
AND METHOD OF MAKING THE SAME



(57) Abstract: A reinforced molded  
article having reinforced protrusions  
extending from the surface of the article  
is suitable for molding into automobile  
trim. The article comprises at least one  
thermoplastic; about 2 % to about 15 %  
by volume reinforcing particles having  
one or more layers of 0.7 nm-1.2 nm  
thick platelets, wherein more than about  
50 % of the reinforcing particles are  
less than about 20 layers thick; whereby  
the reinforcing particles reinforce a  
protrusion from the surface of the  
molded article, the protrusion having  
a thickness of less than 1/10 inch. A  
method of producing reinforced articles  
comprising this reinforced protrusion is  
also disclosed.

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**(48) Date of publication of this corrected version:**

4 October 2001

*For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.*

**(15) Information about Correction:**

see PCT Gazette No. 40/2001 of 4 October 2001, Section II



**LOW PRESSURE COMPRESSION MOLDED PARTS HAVING  
NANO-PARTICLE REINFORCED PROTRUSIONS  
AND METHOD OF MAKING THE SAME**

5    BACKGROUND OF THE INVENTION

Automobile interior trim is often engineered to minimize wall thickness, while maintaining desired structural characteristics. Greater wall thickness of such molded articles requires more raw material per unit part, thereby undesirably increasing the cost of production and increasing vehicle weight. Furthermore, greater wall thicknesses slow down production time due to longer cycling periods needed to permit cooling of thicker molded regions.

Automotive trim components or articles, such as interior panels are often molded from thermoplastic to have various protrusions extending from a broad panel surface, which protrusions serve different functions. For example, some trim components are provided with stiffening ribs to reduce twisting or flexing of the part. The same or other trim components may be provided with fastening bosses that add rigidity and/or strength to areas of the part that are to be secured or fastened to another structure. For example, a screw receiving hole in a molded article may be surrounded by an annular protrusion for support. Such annular protrusion may also have radially outwardly extending protrusions (as an asterisk) to provide further support. As another example, standoffs may be formed on the broad surface of the part to provide proper spacing from an abutting component. As a further example, a protrusion may be in the form of a

dog house or cage, which is used to secure the article or trim component to some other part, e.g., by a hook.

Because it is desirable to manufacture automotive parts with the least amount of material as possible, without sacrificing performance, it is desirable to make the types of protrusions mentioned above as small as possible, so long as they achieve their intended function. Oftentimes, it is desirable to make the protrusions with a thickness of 1/10" or less (i.e., measured in a direction parallel to the surface from which the protrusion protrudes and perpendicular to the longitudinal direction of the protrusion).

It can be appreciated that protrusions of such narrow cross section may be subject to chipping or breakage. As the protrusion protrudes further from the base surface, it becomes more prone to breakage. In addition, several of such protrusions are of a tapered configuration terminating in a relatively narrow pointed tip. Such tip is often less than 1/10" thick and is highly prone to chipping.

Of course, almost all thermoplastic automotive trim components are reinforced by reinforcement materials. More specifically, it is known to use glass fibers to reinforce thermoplastic trim components. Such glass fibers typically have a length on the order of about 1/8". When glass-reinforced thermoplastic materials are molded in high pressure injection molding operations (e.g., of pressure levels greater than 15,000 PSI), movement of the molten material, for example, through a gate and runner system, causes the glass fibers to align themselves longitudinally with the longitudinal or longer

extent of the projection. In this manner, even though the glass fibers have a length greater than the thickness of the protrusions, the thickness or width of the aligned fibers (typically about 6-20 microns) will fit into the protrusions to reinforce the protrusions adequately.

5           However, for certain applications, it is desirable to mold the thermoplastic articles in a low pressure compression molding method (e.g., less than 3,000 PSI). In such method, molten thermoplastic is introduced into a cavity. The mold is then closed, and excess material is squeezed between the die surfaces so that the molten material fills all gaps and shapes to form the  
10   part. The part can thus be finished in a one-step process.

One drawback with the conventional low pressure compression molding methods, however, is that where a part is to be highly reinforced, e.g., requiring 25-35% by volume glass fibers, the glass reinforcement fibers inhibit substantial flow of molten material. As a result, the fibers do not align with  
15   the longitudinal direction of the protrusions, and an insufficient amount of glass fibers will enter into protrusions of thicknesses of 1/10" or less. Thus, these protrusions would need to be made thicker, or otherwise not be reinforced to the extent desirable.

It is an object of the invention to provide a highly reinforced molded  
20   part that can be provided with equally reinforced protrusions of a thickness less than 0.1". In order to achieve this object and to overcome the problems noted above, the present invention provides a reinforced molded article comprising a main portion which has opposing major surfaces defining a

thickness of the main portion. A protrusion is integrally molded with the main portion and protrudes from one of the surfaces, the protrusion having a thickness of less than the thickness of the main portion and less than about 0.1". The protrusion has a height of at least twice the thickness of the protrusion. The main portion and the protrusion are formed from a material comprising at least one thermoplastic, and about 2% to about 15%, by volume, of reinforcing particles. The particles each comprise one or more layers, wherein at least 50% of the reinforcing particles are less than about 20 layers thick, at least 99% of the reinforcing particles are less than about 30 layers thick, and the layers comprise platelets having a thickness of between about 0.7 nm and 1.2 nm.

It is a further object of the invention to provide a method of manufacturing a highly reinforced molded part that has the equally reinforced protrusions as discussed above. In accordance with this object, the present invention provides a method of producing a reinforced article comprised of a main portion which has opposing major surfaces defining a thickness of the main portion. A protrusion is integrally molded with the main portion and protrudes from one of the surfaces, the protrusion having a thickness of less than the thickness of the main portion and less than about 0.1". The protrusion has a height of at least twice the thickness of the protrusion. The method prepares a melt of at least one thermoplastic, and about 2% to about 15%, by volume, of reinforcing particles. The particles each comprise one or more layers. At least 50% of the reinforcing particles are less than about 20 layers

thick, at least 99% of the reinforcing particles are less than about 30 layers thick, and the layers comprise platelets having a thickness of between about 0.7 nm and 1.2 nm. The melt is compressed between die surfaces at a pressure of less than 3,000 PSI, the die surfaces having recesses corresponding to the shape of the protrusions and receiving the melt, including the 2%-15% by volume reinforcing particles, in the recesses so that the melt conforms to the shape of the recesses. The melt is cooled, and the cooled portions of the melt that are received in the recesses form the reinforced protrusions.

These and other objects of the invention can be more fully appreciated from the following detailed description of the preferred embodiments.

#### BRIEF DESCRIPTION OF THE DRAWINGS

A preferred embodiment of the present invention is described herein with reference to the drawings wherein:

FIG. 1 is a front elevation view of an inner door panel for a motor vehicle manufactured in accordance with the principles of the present invention;

FIG. 2 is a cross sectional view of a compression molding die assembly used in accordance with the method of the present invention;

FIG. 3 is a perspective view, partly in cross-section, of a reinforced article manufactured in accordance with the principles of the present invention;

FIG. 4. Is a perspective view, partly in cross-section, of another embodiment of a reinforced article manufactured in accordance with the principles of the present invention;

FIG. 5 is a cross sectional view of a compression molding die assembly used in accordance with another embodiment of the method of the present invention; and

FIG. 6 is a cross sectional view of a compression molding die assembly  
5 used in accordance with another embodiment of the method of the present invention.

#### DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

Shown in Fig. 1, is an inner door panel for a motor vehicle, generally  
10 indicated at 10, and used to exemplify certain applications of the present invention. In Fig. 1, several projections are illustrated schematically by the use of dashed lines.

For example, a plurality of stiffening ribs 12 are shown to add stiffness and rigidity to the panel 10, to inhibit bending, flexing or twisting of the panel.  
15 Also illustrated are an array of projections 14, which are used as structural supports for mounting a stereo speaker. This same region is provided with a plurality of bosses 16, which provide supported or reinforced holes through the panel 10, which hold or receive fasteners for affixing the speaker to the panel 10. Also shown are a plurality of dog houses (also known as "cages") 18,  
20 known in the art to be used for securing other structures to the panel 10.

Fig. 2 is a partial cross-sectional view taken through a compression molding apparatus used to form the articles in accordance with the present invention. The apparatus, generally indicated at 20, includes a first die

structure 22 and a second die structure 24. The die structures 22 and 24 have interior die surfaces 26 and 28, respectively, defining the shape of a die cavity corresponding to the shape of the article to be molded.

A plastic melt 30, to be described in greater detail later, is deposited  
5 between the die surfaces 26 and 28 (e.g., on the lower die surface 28 as illustrated in Fig. 2).

The surface 26 of the first die structure 22 defines a recess 32, which recess is used to form projections in accordance with the present invention.

After the melt 30 is provided between the die surfaces 26, 28, the die  
10 surfaces are moved towards one another (e.g., by moving die structure 22 downwardly towards die structure 24). Typically, peripheral portions of the die structures 22, 24 are brought into engagement with one another, leaving a die cavity between the central portions of die structures 22, 24. A sufficient amount of plastic melt 30 is provided between the die structures 22, 24 to fill  
15 the entire cavity completely, including any recesses 32, which are used to form the projections in accordance with the present invention.

It should be appreciated that the present invention concerns applications wherein a projection which is to be formed as a wall thickness of 0.1" or less. Therefore, it should be appreciated that the thickness (t) of the  
20 recess 32, which forms the projection in accordance with the present invention, should also be less than 0.1" thick.

In the compression molding method, any excess plastic material 30 is controllably squeezed out from between the surfaces 26, 28 and the die cavity

into receiving ports. The die cavity is maintained at pressures less than 3,000 PSI during the molding operation.

Fig. 3 is a partial perspective view, partly in section, of an article 40 manufactured in accordance with the present invention. For example, this article 40 may be the door panel 10 illustrated in Fig. 1. As shown in Fig. 3, the article 40 comprises a main portion 42 having opposing major surfaces 44 and 46. Preferably, surfaces 44 and 46 are substantially parallel to one another. The surfaces 44 and 46 define a thickness (a) of the main portion 42. A protrusion 50 (e.g., which may form a stiffening rib 12 in Fig. 1) is integrally molded with the main portion 42 and protrudes from surface 44. The protrusion 50 has a thickness (t), which is less than the thickness (a) of the main portion 42. In addition, the thickness (t) is less than about 0.1". The protrusion 50 has a height (h) of at least twice the thickness (t) of the protrusion. The height (h) is at least twice the thickness (a) of the main portion 42.

As will be described in greater detail, the plastic melt 30, and hence, the integrally molded main portion 42 and protrusion 50 (shown in Fig. 3 after being removed from the die structure 20 and cooled), are formed from a material comprising at least one thermoplastic, and about 2% to about 15% by volume of reinforcing particles. The reinforcing particles each comprise one or more layers, and at least 50% of the reinforcing particles are less than about 20 layers thick. The layers comprise platelets having a thickness of between about 0.7 nm – 1.2 nm.



It is desirable for the thickness (t) of the protrusion 50 to be thinner than the main portion 42 so as to avoid the occurrence of a sink forming on the opposite surface 46 in the region thereof opposite the protrusion 50. The occurrence of this sink may occur during cooling of the material 30 where the protrusion 50 comprises a significant amount of material and would therefore shrink to a significant extent, drawing material from the main portion 42 during cooling. It is preferred for the thickness (t) of the protrusion 50 to have a thickness of less than 80% of the thickness (a) of the main portion 42.

In order for the protrusion 50 to provide a sufficient amount of support for the main portion 42, the height (h) is at least twice the thickness (a) of the base portion 42.

Preferably, the minimum thickness (a) of the base portion 42 is .065". Therefore, the minimum height (h) of the protrusion 50 is about .130".

It should be appreciated, however, that the dog houses (or cages) 18 in Fig. 1 can comprise projections over 1" in height. The cylindrical sleeves of the screw bosses 16 are preferably between ¼" to 1" in height.

Preferably, the height (h) of the protrusion 50 is between 2 times to 30 times the thickness (t) of the protrusion 50.

Irrespective of the fact that the thickness (t) of the protrusion 50 is less than 0.1", it is nevertheless reinforced to the same extent as the main portion 42, and to a greater extent than would be possible with high glass fiber loading. This is due to the particular nature of the molded material 30 used in accordance with the present invention as described below.

The articles (and the plastic melt from which the articles are molded) comprise a composite material of a polymer having dispersed therein reinforcement fillers in the form of very small mineral reinforcement particles. The reinforcement filler particles, also referred to as “nanoparticles” due to the magnitude of their dimensions, each comprise one or more essentially flat platelets. Generally, each platelet has a thickness of between about 0.7-1.2 nanometers. The average platelet thickness is approximately 1 nanometer.

The preferred aspect ratio of the reinforcement particles, which is the largest dimension of a particle divided by the thickness of the particle, is about 50 to about 300. At least 80% of the particles should be within this range. If too many particles have an aspect ratio above 300, the material becomes too viscous for forming parts in an effective and efficient manner. If too many particles have an aspect ratio of smaller than 50, the particle reinforcements will not provide the desired reinforcement characteristics. More preferably, the aspect ratio for each particle is between 100-200. Most preferably at least 90% of the particles have an aspect ratio within the 100-200 range.

The platelet particles or nanoparticles are derivable from larger layered mineral particles. Any layered mineral capable of being intercalated may be employed in the present invention. Layered silicate minerals are preferred. The layered silicate minerals that may be employed include natural and artificial minerals. Non-limiting examples of more preferred minerals include montmorillonite, vermiculite, hectorite, saponite, hydrotalcites, kanemite, sodium octosilicate, magadite, and kenyaite. Mixed Mg and Al hydroxides

may also be used. Various other clays can be used, such as claytone H.Y.

Among the most preferred minerals is montmorillonite.

To exfoliate the larger mineral particles into their constituent layers, different methods may be employed. For example, swellable layered minerals, such as montmorillonite and saponite are known to intercalate water to expand the inter layer distance of the layered mineral, thereby facilitating exfoliation and dispersion of the layers uniformly in water. Dispersion of layers in water is aided by mixing with high shear. The mineral particles may also be exfoliated by a shearing process in which the mineral particles are impregnated with water, then frozen, and then dried. The freeze dried particles are then mixed into molten polymeric material and subjected to a high sheer mixing operation so as to peel individual platelets from multi-platelet particles and thereby reduce the particle sizes to the desired range.

The polymer composites of the present invention are prepared by combining the platelet mineral with the desired polymer in the desired ratios. The components can be blended by general techniques known to those skilled in the art. For example, the components can be blended and then melted in mixers or extruders. The ratios will be determined based on, for example, desired dimensional stabilization and/or desired mechanical properties of the final molded article.

Additional specific preferred methods, for the purposes of the present invention, for forming a polymer composite having dispersed therein exfoliated layered particles are disclosed in U.S. Patent Nos. 5,717,000,

5,747,560, 5,698,624, and WO 93/11190, each of which is hereby incorporated by reference. For additional background, the following are also incorporated by reference: U.S. Patent Nos. 4,739,007 and 5,652,284.

Generally, compression molding processes are preferred for certain high volume production of reinforced plastics. Automotive interior trim parts produced by low pressure compression molding can be very complex with fine detail and close dimensional tolerance. Thus, thin, reinforced molded-in inserts for screws, bearings, or other attachments in automotive trim may be produced by compression molding according to the invention. Reinforced bosses or other hollow circular standoffs into which a screw can be thread may be made as well. Reinforced bosses having small ribs for even greater reinforcement are also contemplated according to the invention. Stiffening ribs may be integrally molded into automobile interior trim according to the invention. Ribs forming hooks may be reinforced according to the invention. All such integrally molded, reinforced protruding elements have a thickness of less than 1/10 inch and extend from a primary trim portion or body.

Typical resins used in low pressure compression molding include nylon, polypropylene, thermoplastic polyester and polycarbonate. The process permits use of recycled materials, such as scrap polyolefins. Preferably, the thermoplastic used in the present invention is a polyolefin or a homogenous or copolymer blend of polyolefins. The preferred polyolefin is at least one member selected from the group consisting of polypropylene, ethylene-propylene copolymers, thermoplastic olefins (TPOs), and thermoplastic

polyolefin elastomers (TPEs). For high performance applications, engineering thermoplastics are most preferred. Such engineering thermoplastic resins may include polycarbonate (PC), acrylonitrile butadiene styrene (ABS), a PC/ABS blend, polyethylene terephthalates (PET), polybutylene terephthalates (PBT),  
5 polyphenylene oxide (PPO), or the like.

The exfoliation of layered mineral particles into constituent layers need not be complete in order to achieve the objects of the present invention. The present invention contemplates that more than 50% of the particles should be less than about 20 nanometers in thickness. Otherwise stated, more than about  
10 50% of the particles should be less than about 20 platelets stacked upon one another in the thickness direction. In addition, at least 99% of the particles should have a thickness of less than about 30 layers. Preferably, at least 90 % of the particles should have a thickness of less than about 5 layers. It is most preferable to have as many particles as possible to be as small as possible,  
15 ideally including only a single platelet. Particles having more than 30 layers may behave as stress concentrators and are preferably avoided, to the extent possible.

Generally, in accordance with the present invention, each of the automotive parts that can be manufactured in accordance with the principles of  
20 the present invention should contain nanoparticle reinforcement in amounts less than 15% by volume of the total volume of the part. The balance of the part is to comprise an appropriate thermoplastic material and optionally, suitable additives. If greater than 15% by volume of reinforcement filler is

used, the viscosity of the composition becomes higher than what is desirable for molding. Preferably, the amount of reinforcing nanoparticles is greater than 2% by volume, as lower amounts would not achieve the desired increase in strength.

5            Preferably, relatively rigid compression molded trim parts having thin protrusions comprise reinforcement particles of the type described herein at about 2-15% of the total volume of the part, with the balance comprising the thermoplastic substrate. It is even more preferable for these interior panels to have reinforcement particles of the type contemplated herein comprising about  
10    3%-8% of the total volume of the part. For some applications, inclusion of about 3%-5% by volume reinforcing nanoparticles is optimal.

            When about 90% of the nanoparticles in the composition are less than 5 nm in thickness, a more preferred uniform distribution of the particles occurs in the resin, which translates into evenly distributed resin throughout the mold  
15    cavity. The extremely small size of these reinforcing particles permits them to fill thin mold cavity areas less than 1/10 inch thick without impairing resin flow. A reduction to near elimination of unreinforced protrusions occurs in the final molded product, accordingly.

            In addition to reinforcing agents, other additives may optionally be  
20    included in the polymer composition to improve processability. For example, aging modifiers, such as glycerol monostearate, are useful additives in polymer compositions for molding. Aging modifiers are typically present in an amount from about 0.5% to about 5% thermoplastic resin. Release agents may also be

present to enhance removal of the final product from the mold. Other additives include pigments, heat stabilizers, antioxidants, flame retardants, ultraviolet absorbing agents and the like.

Reinforced articles of the invention exhibit improved properties over non-reinforced articles. For example, polyethylene articles having about 5% nanoparticles by volume, wherein 90% of the particles have 5 or fewer layers, increased flexural modulus by 2.5 to about 3 times over compositions lacking reinforcing nanoparticles, as measured under ASTM D790 test conditions. This 5% nanoparticle polyethylene article exhibited > 200% elongation to rupture. By contrast, about 25% glass fiber reinforcement is required in such articles to achieve an equivalent modulus. Polypropylene articles according to the invention showed about a 60% improvement in flexural modulus over articles lacking reinforcement nanoparticles. Thus, the use of reinforcing nanoparticles according to the invention provides articles having good flexural stiffness.

Fig. 4 is a partial perspective view, partly in section, and illustrating another application of the present invention. Specifically, Fig. 4 illustrates and article 70 having projections forming a boss 80. The article 70 may be a panel 10 as illustrated in Fig. 1, and boss 80 may be one of the bosses 16 illustrated in Fig. 1. The boss 80 is formed on a main portion 82 and defines a hole through the article 70. The protrusion 80 is integrally compression molded with main portion 82. The protrusion includes a cylindrical wall portion 84 and a plurality of radially projecting support ribs 86. The wall thickness of the

projections is less than 0.1". For example, the wall thickness (t) of the cylindrical wall portion 84 is less than 0.1". The cylindrical wall portion 84 has a height (h) of at least twice the thickness (t). The height (h) is at least twice the thickness (a) of the main portion 82. The article 70 is compression  
5 molded from the same material specified with respect to the previous embodiment. The boss 80 is constructed and arranged to receive a fastener therethrough to fix a structure to article 70.

FIG. 5 illustrates another embodiment of the method in accordance with the present invention. In FIG. 5, a decorative material 90 is placed  
10 between the first die structure 22 and the second die structure 24 before the hot melt material 30 is introduced into the die cavity. The hot melt is then injected or poured onto the surface of the decorative material 90 and adhered thereto as a result of the curing process. In one embodiment the decorative material 90 is selected from flexible materials, that are calendared or embossed to provide a  
15 leather-like appearance. In such an embodiment, it is preferred that the decorative material be selected from a group consisting of vinyl, polyvinylchloride/acrylonitrile, butadiene, styrene (PVC/ABS), thermoplastic polyolefins (TPO), polypropylene (PP), and thermoplastic polyurethanes (TPU).

20 FIG. 6 illustrates yet another embodiment of the method in accordance with the present invention. In FIG. 6, a decorative material 90 is again placed between the first die structure 22 and the second die structure 24 before the hot melt material 30 is introduced into the die cavity. The hot melt is then



injected or poured onto the surface of the decorative material 90 and adhered thereto as a result of the curing process. In this embodiment, the decorative material comprises a fabric, cloth, or carpeting layer 92 as an aesthetically appealing skin for the interior of the vehicle. The decorative material 90  
5 further includes a second layer 94 which is a bonded foam layer and/or a film layer that provide a semi-soft feel and to keep molten plastic from penetrating into the fabric, cloth or carpeting layer 92.

It should be appreciated that the foregoing description is illustrative in nature and that the present invention includes modifications, changes, and  
10 equivalents thereof, without departure from the scope of the invention.

What is claimed is:

1. A reinforced molded article comprising:

a main portion having opposing major surfaces defining a thickness of said main portion;

a protrusion integrally molded with said main portion and protruding from one of said surfaces, said protrusion having a thickness of less than the thickness of said main portion and less than about 0.1", said protrusion having a height of at least twice the thickness of said protrusion,

said main portion and said protrusion being formed from a material comprising at least one thermoplastic, and about 2% to about 15%, by volume, reinforcing particles,

said particles each comprising one or more layers, at least 50% of said reinforcing particles being less than about 20 layers thick, at least 99% of said reinforcing particles being less than about 30 layers thick, and said layers comprising platelets having a thickness of between about 0.7 nm and 1.2 nm.

2. A reinforced molded article according to claim 1, further comprising a decorative material adhered to an opposite surface disposed on a side of said main portion opposite said one of said surfaces.

3. A reinforced molded article according to claim 2, wherein said decorative material is made from a material selected from a group consisting of vinyl, PVC/ABS, TPO, PP, and TPU.
4. A reinforced molded article according to claim 2, wherein said decorative material is made from fabric, cloth, or carpeting.
5. A reinforced molded article according to claim 4, wherein said decorative material further includes has at least one of a bonded foam layer and a film layer disposed in contact with said opposite surface.
6. A method of producing a reinforced article comprising a main portion having opposing major surfaces defining a thickness of said main portion, a protrusion integrally molded with said main portion and protruding from one of said surfaces, said protrusion having a thickness of less than the thickness of said main portion and less than about 0.1", said protrusion having a height of at least twice the thickness of said protrusion, said method comprising:
  - preparing a melt of at least one thermoplastic, and about 2% to about 15%, by volume, of reinforcing particles,
  - said particles each comprising one or more layers, at least 50% of said reinforcing particles being less than about 20 layers thick, at least 99% of said reinforcing particles being less than about 30 layers thick, and said layers comprising platelets having a thickness of between about 0.7 nm and 1.2 nm;

compressing said melt between die surfaces at a pressure of less than 3,000 PSI, said die surfaces having recesses corresponding to the shape of said protrusions,

receiving said melt, including said 2%-15% by volume reinforcing particles, in said recesses so that said melt conforms to the shape of said recesses;

cooling said melt, wherein cooled portions of said melt received in said recesses form said reinforced protrusions.

7. A method according to claim 6, further comprising:

placing a decorative material between said die surfaces and contacting said melt with said decorative material so as to adhere said decorative material to said melt.

8. A method according to claim 7, wherein said decorative material contacts a surface of said die cavity opposite said surface having said recesses.

9. A method according to claim 7, wherein said decorative material is made from a material selected from a group consisting of vinyl, PVC/ABS, TPO, PP, and TPU.

10. A method according to claim 7, wherein said decorative material includes a first layer made fabric, cloth, or carpeting, and a second layer comprising at least one of a bonded foam layer and a film layer disposed in contact with said first layer, said second layer contacting said melt between said die surfaces to prevent said melt from permeating through said first layer.

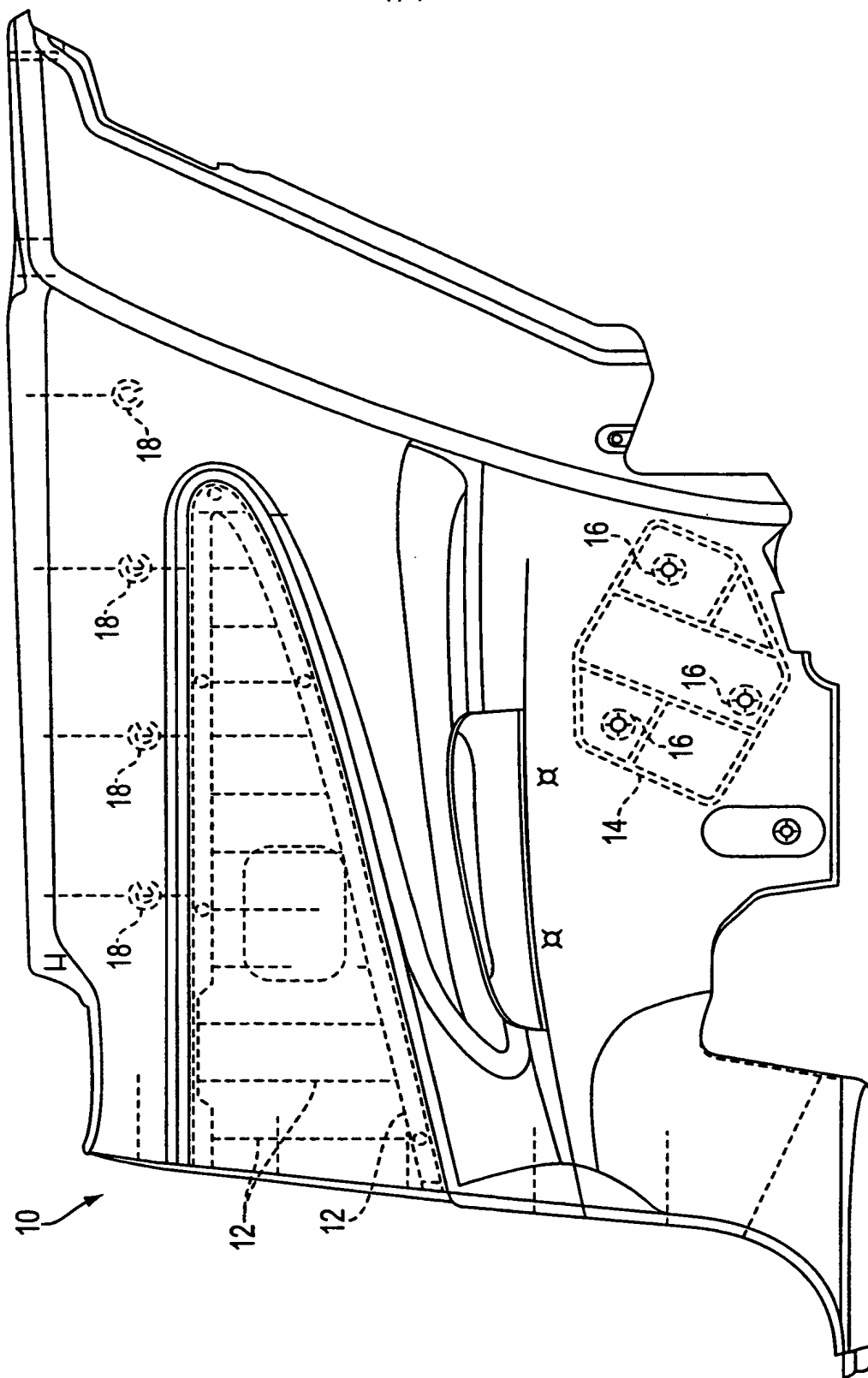


FIG. 1

2/4

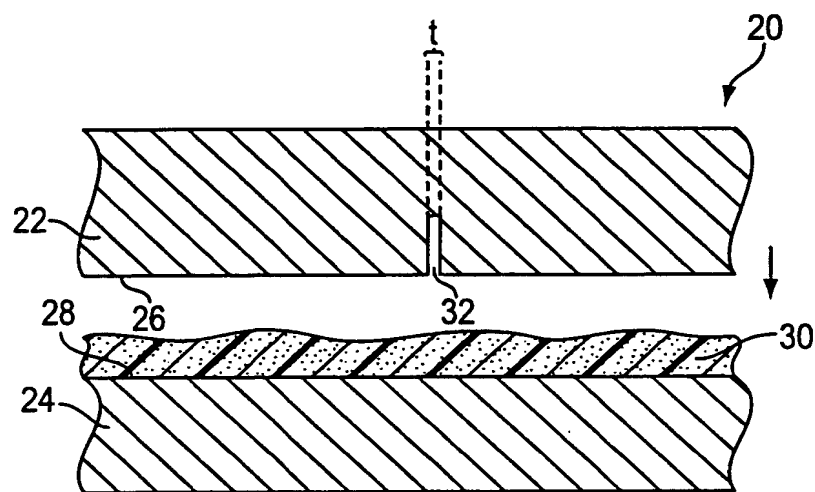


FIG. 2

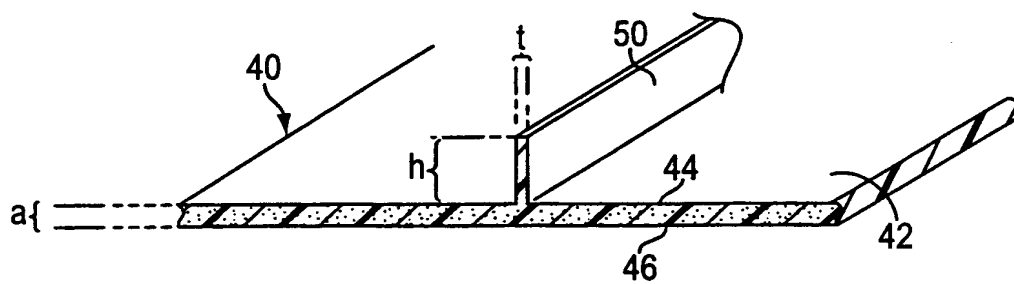


FIG. 3

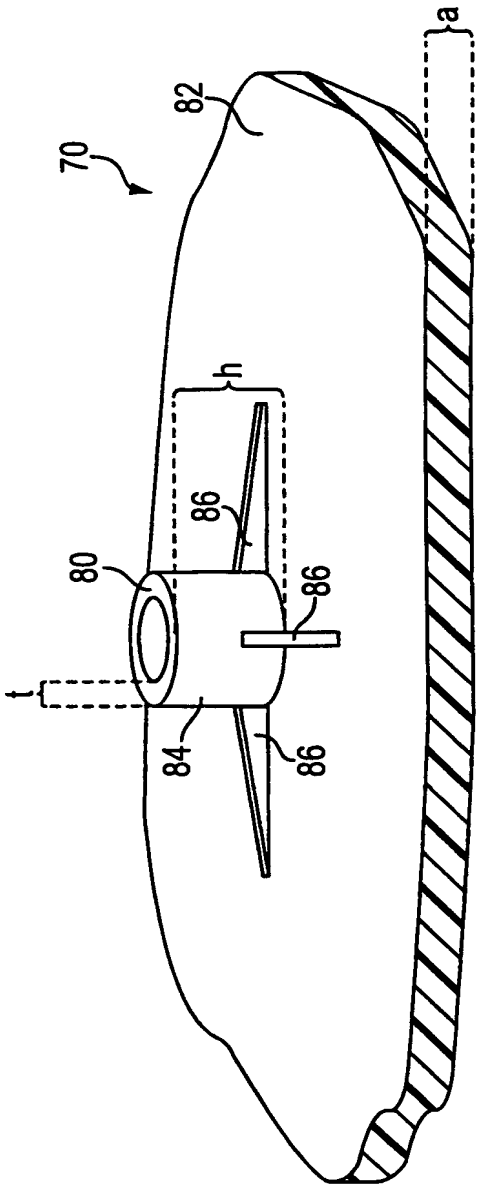


FIG. 4



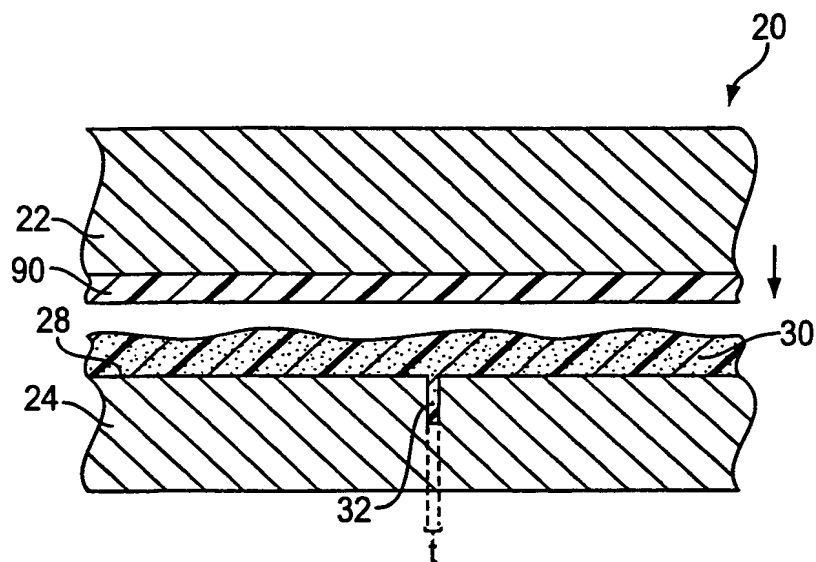


FIG. 5

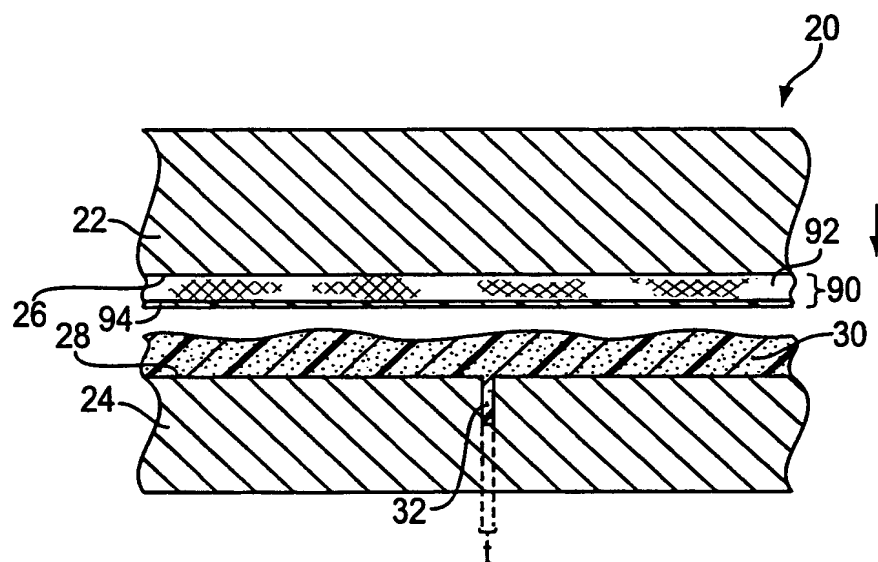


FIG. 6

# INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 99/29992

**A. CLASSIFICATION OF SUBJECT MATTER**  
IPC 7 B29C67/00 C08K3/34

According to International Patent Classification (IPC) or to both national classification and IPC

**B. FIELDS SEARCHED**

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 B29C C08K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

**C. DOCUMENTS CONSIDERED TO BE RELEVANT**

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 4 739 007 A (OKADA AKANE ET AL) 19 April 1988 (1988-04-19) cited in the application abstract	1,6
Y	column 3, line 30 column 3, line 42 - line 48 ---	2-5,7-10
Y	US 4 572 856 A (GEMBINSKI JOHN C) 25 February 1986 (1986-02-25) the whole document ---	2-5,7-10
X	US 5 747 560 A (MAXFIELD MACRAE ET AL) 5 May 1998 (1998-05-05) column 6, line 60 -column 24, line 49 --- -/--	1,6

☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

\* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance

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"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

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"&" document member of the same patent family

Date of the actual completion of the international search

18 April 2000

Date of mailing of the international search report

28/04/2000

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# INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 99/29992

## C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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A	DE 196 25 797 A (VOLKSWAGENWERK AG) 9 January 1997 (1997-01-09) column 2, line 48 -column 4, line 4; claim 1 -----	1,6

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Information on patent family members

Int. tional Application No

PCT/US 99/29992

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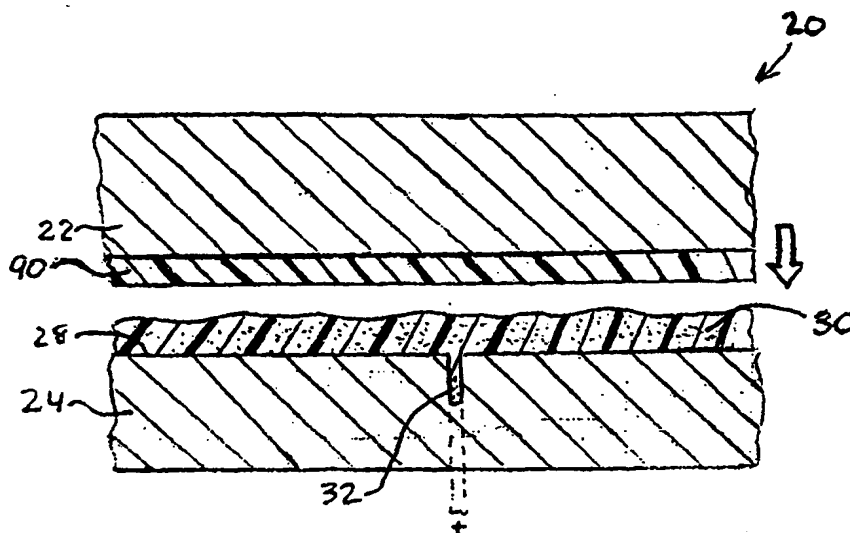
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(54) Title: LOW PRESSURE COMPRESSION MOLDED PARTS HAVING NANO-PARTICLE REINFORCED PROTRUSIONS AND METHOD OF MAKING THE SAME

(57) Abstract

A reinforced molded article having reinforced protrusions extending from the surface of the article is suitable for molding into automobile trim. The article comprises at least one thermoplastic; about 2 % to about 15 % by volume reinforcing particles having one or more layers of 0.7 nm-1.2 nm thick platelets, wherein more than about 50 % of the reinforcing particles are less than about 20 layers thick; whereby the reinforcing particles reinforce a protrusion from the surface of the molded article, the protrusion having a thickness of less than 1/10 inch. A method of producing reinforced articles comprising this reinforced protrusion is also disclosed.



# APPLICATION UNDER UNITED STATES PATENT LAWS

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Invention: **LOW PRESSURE COMPRESSION MOLDED PARTS HAVING NANO-PARTICLE  
REINFORCED PROTRUSIONS AND METHOD OF MAKING THE SAME**

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## SPECIFICATION

**LOW PRESSURE COMPRESSION MOLDED PARTS HAVING  
NANO-PARTICLE REINFORCED PROTRUSIONS  
AND METHOD OF MAKING THE SAME**

5    **BACKGROUND OF THE INVENTION**

Automobile interior trim is often engineered to minimize wall thickness, while maintaining desired structural characteristics. Greater wall thickness of such molded articles requires more raw material per unit part, thereby undesirably increasing the cost of production and increasing vehicle weight. Furthermore, greater wall  
10    thicknesses slow down production time due to longer cycling periods needed to permit cooling of thicker molded regions.

Automotive trim components or articles, such as interior panels are often molded from thermoplastic to have various protrusions extending from a broad panel surface, which protrusions serve different functions. For example, some trim components are  
15    provided with stiffening ribs to reduce twisting or flexing of the part. The same or other trim components may be provided with fastening bosses that add rigidity and/or strength to areas of the part that are to be secured or fastened to another structure. For example, a screw receiving hole in a molded article may be surrounded by an annular protrusion for support. Such annular protrusion may also have radially outwardly extending  
20    protrusions (as an asterisk) to provide further support. As another example, standoffs may be formed on the broad surface of the part to provide proper spacing from an abutting component. As a further example, a protrusion may be in the form of a dog house or cage, which is used to secure the article or trim component to some other part, e.g., by a hook.

Because it is desirable to manufacture automotive parts with the least amount of material as possible, without sacrificing performance, it is desirable to make the types of protrusions mentioned above as small as possible, so long as they achieve their intended function. Oftentimes, it is desirable to make the protrusions with a thickness of 1/10" or less (i.e., measured in a direction parallel to the surface from which the protrusion protrudes and perpendicular to the longitudinal direction of the protrusion).

It can be appreciated that protrusions of such narrow cross section may be subject to chipping or breakage. As the protrusion protrudes further from the base surface, it becomes more prone to breakage. In addition, several of such protrusions are of a tapered configuration terminating in a relatively narrow pointed tip. Such tip is often less than 1/10" thick and is highly prone to chipping.

Of course, almost all thermoplastic automotive trim components are reinforced by reinforcement materials. More specifically, it is known to use glass fibers to reinforce thermoplastic trim components. Such glass fibers typically have a length on the order of about 1/8". When glass-reinforced thermoplastic materials are molded in high pressure injection molding operations (e.g., of pressure levels greater than 15,000 PSI), movement of the molten material, for example, through a gate and runner system, causes the glass fibers to align themselves longitudinally with the longitudinal or longer extent of the projection. In this manner, even though the glass fibers have a length greater than the thickness of the protrusions, the thickness or width of the aligned fibers (typically about 6-20 microns) will fit into the protrusions to reinforce the protrusions adequately.

However, for certain applications, it is desirable to mold the thermoplastic articles in a low pressure compression molding method (e.g., less than 3,000 PSI). In such method, molten thermoplastic is introduced into a cavity. The mold is then



closed, and excess material is squeezed between the die surfaces so that the molten material fills all gaps and shapes to form the part. The part can thus be finished in a one-step process.

One drawback with the conventional low pressure compression molding methods, however, is that where a part is to be highly reinforced, e.g., requiring 25-35% by volume glass fibers, the glass reinforcement fibers inhibit substantial flow of molten material. As a result, the fibers do not align with the longitudinal direction of the protrusions, and an insufficient amount of glass fibers will enter into protrusions of thicknesses of 1/10" or less. Thus, these protrusions would need to be made thicker, or otherwise not be reinforced to the extent desirable.

It is an object of the invention to provide a highly reinforced molded part that can be provided with equally reinforced protrusions of a thickness less than 0.1". In order to achieve this object and to overcome the problems noted above, the present invention provides a reinforced molded article comprising a main portion which has opposing major surfaces defining a thickness of the main portion. A protrusion is integrally molded with the main portion and protrudes from one of the surfaces, the protrusion having a thickness of less than the thickness of the main portion and less than about 0.1". The protrusion has a height of at least twice the thickness of the protrusion. The main portion and the protrusion are formed from a material comprising at least one thermoplastic, and about 2% to about 15%, by volume, of reinforcing particles. The particles each comprise one or more layers, wherein at least 50% of the reinforcing particles are less than about 20 layers thick, at least 99% of the reinforcing particles are less than about 30 layers thick, and the layers comprise platelets having a thickness of between about 0.7 nm and 1.2 nm.

It is a further object of the invention to provide a method of manufacturing a highly reinforced molded part that has the equally reinforced protrusions as discussed above. In accordance with this object, the present invention provides a method of producing a reinforced article comprised of a main portion which has opposing major surfaces defining a thickness of the main portion. A protrusion is integrally molded with the main portion and protrudes from one of the surfaces, the protrusion having a thickness of less than the thickness of the main portion and less than about 0.1". The protrusion has a height of at least twice the thickness of the protrusion. The method prepares a melt of at least one thermoplastic, and about 2% to about 15%, by volume, of reinforcing particles. The particles each comprise one or more layers. At least 50% of the reinforcing particles are less than about 20 layers thick, at least 99% of the reinforcing particles are less than about 30 layers thick, and the layers comprise platelets having a thickness of between about 0.7 nm and 1.2 nm. The melt is compressed between die surfaces at a pressure of less than 3,000 PSI, the die surfaces having recesses corresponding to the shape of the protrusions and receiving the melt, including the 2%-15% by volume reinforcing particles, in the recesses so that the melt conforms to the shape of the recesses. The melt is cooled, and the cooled portions of the melt that are received in the recesses form the reinforced protrusions.

These and other objects of the invention can be more fully appreciated from the following detailed description of the preferred embodiments.

#### BRIEF DESCRIPTION OF THE DRAWINGS

A preferred embodiment of the present invention is described herein with reference to the drawings wherein:

FIG. 1 is a front elevation view of an inner door panel for a motor vehicle manufactured in accordance with the principles of the present invention;

FIG. 2 is a cross sectional view of a compression molding die assembly used in accordance with the method of the present invention;

5        FIG. 3 is a perspective view, partly in cross-section, of a reinforced article manufactured in accordance with the principles of the present invention;

FIG. 4. Is a perspective view, partly in cross-section, of another embodiment of a reinforced article manufactured in accordance with the principles of the present invention;

10       FIG. 5 is a cross sectional view of a compression molding die assembly used in accordance with another embodiment of the method of the present invention; and

FIG. 6 is a cross sectional view of a compression molding die assembly used in accordance with another embodiment of the method of the present invention.

15       DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

Shown in Fig. 1, is an inner door panel for a motor vehicle, generally indicated at 10, and used to exemplify certain applications of the present invention. In Fig. 1, several projections are illustrated schematically by the use of dashed lines.

For example, a plurality of stiffening ribs 12 are shown to add stiffness and  
20       rigidity to the panel 10, to inhibit bending, flexing or twisting of the panel. Also illustrated are an array of projections 14, which are used as structural supports for mounting a stereo speaker. This same region is provided with a plurality of bosses 16, which provide supported or reinforced holes through the panel 10, which hold or receive fasteners for affixing the speaker to the panel 10. Also shown are a plurality

of dog houses (also known as "cages") 18, known in the art to be used for securing other structures to the panel 10.

Fig. 2 is a partial cross-sectional view taken through a compression molding apparatus used to form the articles in accordance with the present invention. The apparatus, generally indicated at 20, includes a first die structure 22 and a second die structure 24. The die structures 22 and 24 have interior die surfaces 26 and 28, respectively, defining the shape of a die cavity corresponding to the shape of the article to be molded.

A plastic melt 30, to be described in greater detail later, is deposited between the die surfaces 26 and 28 (e.g., on the lower die surface 28 as illustrated in Fig. 2).

The surface 26 of the first die structure 22 defines a recess 32, which recess is used to form projections in accordance with the present invention.

After the melt 30 is provided between the die surfaces 26, 28, the die surfaces are moved towards one another (e.g., by moving die structure 22 downwardly towards die structure 24). Typically, peripheral portions of the die structures 22, 24 are brought into engagement with one another, leaving a die cavity between the central portions of die structures 22, 24. A sufficient amount of plastic melt 30 is provided between the die structures 22, 24 to fill the entire cavity completely, including any recesses 32, which are used to form the projections in accordance with the present invention.

It should be appreciated that the present invention concerns applications wherein a projection which is to be formed as a wall thickness of 0.1" or less. Therefore, it should be appreciated that the thickness (t) of the recess 32, which forms the projection in accordance with the present invention, should also be less than 0.1" thick.

In the compression molding method, any excess plastic material 30 is controllably squeezed out from between the surfaces 26, 28 and the die cavity into receiving ports. The die cavity is maintained at pressures less than 3,000 PSI during the molding operation.

5 Fig. 3 is a partial perspective view, partly in section, of an article 40 manufactured in accordance with the present invention. For example, this article 40 may be the door panel 10 illustrated in Fig. 1. As shown in Fig. 3, the article 40 comprises a main portion 42 having opposing major surfaces 44 and 46. Preferably, surfaces 44 and 46 are substantially parallel to one another. The surfaces 44 and 46  
10 define a thickness (a) of the main portion 42. A protrusion 50 (e.g., which may form a stiffening rib 12 in Fig. 1) is integrally molded with the main portion 42 and protrudes from surface 44. The protrusion 50 has a thickness (t), which is less than the thickness (a) of the main portion 42. In addition, the thickness (t) is less than about 0.1". The protrusion 50 has a height (h) of at least twice the thickness (t) of the  
15 protrusion. The height (h) is at least twice the thickness (a) of the main portion 42.

As will be described in greater detail, the plastic melt 30, and hence, the integrally molded main portion 42 and protrusion 50 (shown in Fig. 3 after being removed from the die structure 20 and cooled), are formed from a material comprising at least one thermoplastic, and about 2% to about 15% by volume of reinforcing  
20 particles. The reinforcing particles each comprise one or more layers, and at least 50% of the reinforcing particles are less than about 20 layers thick. The layers comprise platelets having a thickness of between about 0.7 nm – 1.2 nm.

It is desirable for the thickness (t) of the protrusion 50 to be thinner than the main portion 42 so as to avoid the occurrence of a sink forming on the opposite  
25 surface 46 in the region thereof opposite the protrusion 50. The occurrence of this

sink may occur during cooling of the material 30 where the protrusion 50 comprises a significant amount of material and would therefore shrink to a significant extent, drawing material from the main portion 42 during cooling. It is preferred for the thickness (t) of the protrusion 50 to have a thickness of less than 80% of the thickness (a) of the main portion 42.

In order for the protrusion 50 to provide a sufficient amount of support for the main portion 42, the height (h) is at least twice the thickness (a) of the base portion 42.

Preferably, the minimum thickness (a) of the base portion 42 is .065".

Therefore, the minimum height (h) of the protrusion 50 is about .130".

It should be appreciated, however, that the dog houses (or cages) 18 in Fig. 1 can comprise projections over 1" in height. The cylindrical sleeves of the screw bosses 16 are preferably between ¼" to 1" in height.

Preferably, the height (h) of the protrusion 50 is between 2 times to 30 times the thickness (t) of the protrusion 50.

Irrespective of the fact that the thickness (t) of the protrusion 50 is less than 0.1", it is nevertheless reinforced to the same extent as the main portion 42, and to a greater extent than would be possible with high glass fiber loading. This is due to the particular nature of the molded material 30 used in accordance with the present invention as described below.

The articles (and the plastic melt from which the articles are molded) comprise a composite material of a polymer having dispersed therein reinforcement fillers in the form of very small mineral reinforcement particles. The reinforcement filler particles, also referred to as "nanoparticles" due to the magnitude of their dimensions, each comprise one or more essentially flat platelets. Generally, each platelet has a

thickness of between about 0.7-1.2 nanometers. The average platelet thickness is approximately 1 nanometer.

The preferred aspect ratio of the reinforcement particles, which is the largest dimension of a particle divided by the thickness of the particle, is about 50 to about 300. At least 80% of the particles should be within this range. If too many particles have an aspect ratio above 300, the material becomes too viscous for forming parts in an effective and efficient manner. If too many particles have an aspect ratio of smaller than 50, the particle reinforcements will not provide the desired reinforcement characteristics. More preferably, the aspect ratio for each particle is between 100-200. Most preferably at least 90% of the particles have an aspect ratio within the 100-200 range.

The platelet particles or nanoparticles are derivable from larger layered mineral particles. Any layered mineral capable of being intercalated may be employed in the present invention. Layered silicate minerals are preferred. The layered silicate minerals that may be employed include natural and artificial minerals. Non-limiting examples of more preferred minerals include montmorillonite, vermiculite, hectorite, saponite, hydrotalcites, kanemite, sodium octosilicate, magadite, and kenyaite. Mixed Mg and Al hydroxides may also be used. Various other clays can be used, such as claytone H.Y. Among the most preferred minerals is montmorillonite.

To exfoliate the larger mineral particles into their constituent layers, different methods may be employed. For example, swellable layered minerals, such as montmorillonite and saponite are known to intercalate water to expand the inter layer distance of the layered mineral, thereby facilitating exfoliation and dispersion of the layers uniformly in water. Dispersion of layers in water is aided by mixing with high shear. The mineral particles may also be exfoliated by a shearing process in which the

mineral particles are impregnated with water, then frozen, and then dried. The freeze dried particles are then mixed into molten polymeric material and subjected to a high sheer mixing operation so as to peel individual platelets from multi-platelet particles and thereby reduce the particle sizes to the desired range.

5       The polymer composites of the present invention are prepared by combining the platelet mineral with the desired polymer in the desired ratios. The components can be blended by general techniques known to those skilled in the art. For example, the components can be blended and then melted in mixers or extruders. The ratios will be determined based on, for example, desired dimensional stabilization and/or  
10   desired mechanical properties of the final molded article.

Additional specific preferred methods, for the purposes of the present invention, for forming a polymer composite having dispersed therein exfoliated layered particles are disclosed in U.S. Patent Nos. 5,717,000, 5,747,560, 5,698,624, and WO 93/11190, each of which is hereby incorporated by reference. For additional  
15   background, the following are also incorporated by reference: U.S. Patent Nos. 4,739,007 and 5,652,284.

Generally, compression molding processes are preferred for certain high volume production of reinforced plastics. Automotive interior trim parts produced by low pressure compression molding can be very complex with fine detail and close  
20   dimensional tolerance. Thus, thin, reinforced molded-in inserts for screws, bearings, or other attachments in automotive trim may be produced by compression molding according to the invention. Reinforced bosses or other hollow circular standoffs into which a screw can be thread may be made as well. Reinforced bosses having small ribs for even greater reinforcement are also contemplated according to the invention.  
25   Stiffening ribs may be integrally molded into automobile interior trim according to the



invention. Ribs forming hooks may be reinforced according to the invention. All such integrally molded, reinforced protruding elements have a thickness of less than 1/10 inch and extend from a primary trim portion or body.

Typical resins used in low pressure compression molding include nylon, polypropylene, thermoplastic polyester and polycarbonate. The process permits use of recycled materials, such as scrap polyolefins. Preferably, the thermoplastic used in the present invention is a polyolefin or a homogenous or copolymer blend of polyolefins. The preferred polyolefin is at least one member selected from the group consisting of polypropylene, ethylene-propylene copolymers, thermoplastic olefins (TPOs), and thermoplastic polyolefin elastomers (TPEs). For high performance applications, engineering thermoplastics are most preferred. Such engineering thermoplastic resins may include polycarbonate (PC), acrylonitrile butadiene styrene (ABS), a PC/ABS blend, polyethylene terephthalates (PET), polybutylene terephthalates (PBT), polyphenylene oxide (PPO), or the like.

The exfoliation of layered mineral particles into constituent layers need not be complete in order to achieve the objects of the present invention. The present invention contemplates that more than 50% of the particles should be less than about 20 nanometers in thickness. Otherwise stated, more than about 50% of the particles should be less than about 20 platelets stacked upon one another in the thickness direction. In addition, at least 99% of the particles should have a thickness of less than about 30 layers. Preferably, at least 90 % of the particles should have a thickness of less than about 5 layers. It is most preferable to have as many particles as possible to be as small as possible, ideally including only a single platelet. Particles having more than 30 layers may behave as stress concentrators and are preferably avoided, to the extent possible.

Generally, in accordance with the present invention, each of the automotive parts that can be manufactured in accordance with the principles of the present invention should contain nanoparticle reinforcement in amounts less than 15% by volume of the total volume of the part. The balance of the part is to comprise an appropriate thermoplastic material and optionally, suitable additives. If greater than 15% by volume of reinforcement filler is used, the viscosity of the composition becomes higher than what is desirable for molding. Preferably, the amount of reinforcing nanoparticles is greater than 2% by volume, as lower amounts would not achieve the desired increase in strength.

Preferably, relatively rigid compression molded trim parts having thin protrusions comprise reinforcement particles of the type described herein at about 2-15% of the total volume of the part, with the balance comprising the thermoplastic substrate. It is even more preferable for these interior panels to have reinforcement particles of the type contemplated herein comprising about 3%-8% of the total volume of the part. For some applications, inclusion of about 3%-5% by volume reinforcing nanoparticles is optimal.

When about 90% of the nanoparticles in the composition are less than 5 nm in thickness, a more preferred uniform distribution of the particles occurs in the resin, which translates into evenly distributed resin throughout the mold cavity. The extremely small size of these reinforcing particles permits them to fill thin mold cavity areas less than 1/10 inch thick without impairing resin flow. A reduction to near elimination of unreinforced protrusions occurs in the final molded product, accordingly.

In addition to reinforcing agents, other additives may optionally be included in the polymer composition to improve processability. For example, aging modifiers,

such as glycerol monostearate, are useful additives in polymer compositions for molding. Aging modifiers are typically present in an amount from about 0.5% to about 5% thermoplastic resin. Release agents may also be present to enhance removal of the final product from the mold. Other additives include pigments, heat stabilizers, antioxidants, flame retardants, ultraviolet absorbing agents and the like.

Reinforced articles of the invention exhibit improved properties over non-reinforced articles. For example, polyethylene articles having about 5% nanoparticles by volume, wherein 90% of the particles have 5 or fewer layers, increased flexural modulus by 2.5 to about 3 times over compositions lacking reinforcing nanoparticles, as measured under ASTM D790 test conditions. This 5% nanoparticle polyethylene article exhibited > 200% elongation to rupture. By contrast, about 25% glass fiber reinforcement is required in such articles to achieve an equivalent modulus.

Polypropylene articles according to the invention showed about a 60% improvement in flexural modulus over articles lacking reinforcement nanoparticles. Thus, the use of reinforcing nanoparticles according to the invention provides articles having good flexural stiffness.

Fig. 4 is a partial perspective view, partly in section, and illustrating another application of the present invention. Specifically, Fig. 4 illustrates and article 70 having projections forming a boss 80. The article 70 may be a panel 10 as illustrated in Fig. 1, and boss 80 may be one of the bosses 16 illustrated in Fig. 1. The boss 80 is formed on a main portion 82 and defines a hole through the article 70. The protrusion 80 is integrally compression molded with main portion 82. The protrusion includes a cylindrical wall portion 84 and a plurality of radially projecting support ribs 86. The wall thickness of the projections is less than 0.1". For example, the wall thickness (t) of the cylindrical wall portion 84 is less than 0.1". The cylindrical wall portion 84

has a height (h) of at least twice the thickness (t). The height (h) is at least twice the thickness (a) of the main portion 82. The article 70 is compression molded from the same material specified with respect to the previous embodiment. The boss 80 is constructed and arranged to receive a fastener therethrough to fix a structure to article

5 70.

FIG. 5 illustrates another embodiment of the method in accordance with the present invention. In FIG. 5, a decorative material 90 is placed between the first die structure 22 and the second die structure 24 before the hot melt material 30 is introduced into the die cavity. The hot melt is then injected or poured onto the surface

10 of the decorative material 90 and adhered thereto as a result of the curing process. In one embodiment the decorative material 90 is selected from flexible materials, that are calendared or embossed to provide a leather-like appearance. In such an embodiment, it is preferred that the decorative material be selected from a group consisting of vinyl, polyvinylchloride/acrylonitrile, butadiene, styrene (PVC/ABS), thermoplastic

15 polyolefins (TPO), polypropylene (PP), and thermoplastic polyurethanes (TPU).

FIG. 6 illustrates yet another embodiment of the method in accordance with the present invention. In FIG. 6, a decorative material 90 is again placed between the first die structure 22 and the second die structure 24 before the hot melt material 30 is introduced into the die cavity. The hot melt is then injected or poured onto the

20 surface of the decorative material 90 and adhered thereto as a result of the curing process. In this embodiment, the decorative material comprises a fabric, cloth, or carpeting layer 92 as an aesthetically appealing skin for the interior of the vehicle. The decorative material 90 further includes a second layer 94 which is a bonded foam layer and/or a film layer that provide a semi-soft feel and to keep molten plastic from

25 penetrating into the fabric, cloth or carpeting layer 92.

It should be appreciated that the foregoing description is illustrative in nature and that the present invention includes modifications, changes, and equivalents thereof, without departure from the scope of the invention.

What is claimed is:

1. A reinforced molded article comprising:

a main portion having opposing major surfaces defining a thickness of said main portion;

a protrusion integrally molded with said main portion and protruding from one of said surfaces, said protrusion having a thickness of less than the thickness of said main portion and less than about 0.1", said protrusion having a height of at least twice the thickness of said protrusion,

said main portion and said protrusion being formed from a material comprising at least one thermoplastic, and about 2% to about 15%, by volume, reinforcing particles,

said particles each comprising one or more layers, at least 50% of said reinforcing particles being less than about 20 layers thick, at least 99% of said reinforcing particles being less than about 30 layers thick, and said layers comprising platelets having a thickness of between about 0.7 nm and 1.2 nm.

2. A reinforced molded article according to claim 1, further comprising a decorative material adhered to an opposite surface disposed on a side of said main portion opposite said one of said surfaces.

3. A reinforced molded article according to claim 2, wherein said decorative material is made from a material selected from a group consisting of vinyl, PVC/ABS, TPO, PP, and TPU.

4. A reinforced molded article according to claim 2, wherein said decorative material is made from fabric, cloth, or carpeting.
5. A reinforced molded article according to claim 4, wherein said decorative material further includes has at least one of a bonded foam layer and a film layer disposed in contact with said opposite surface.
6. A method of producing a reinforced article comprising a main portion having opposing major surfaces defining a thickness of said main portion, a protrusion integrally molded with said main portion and protruding from one of said surfaces, said protrusion having a thickness of less than the thickness of said main portion and less than about 0.1", said protrusion having a height of at least twice the thickness of said protrusion, said method comprising:
  - preparing a melt of at least one thermoplastic, and about 2% to about 15%, by volume, of reinforcing particles,
  - said particles each comprising one or more layers, at least 50% of said reinforcing particles being less than about 20 layers thick, at least 99% of said reinforcing particles being less than about 30 layers thick, and said layers comprising platelets having a thickness of between about 0.7 nm and 1.2 nm;
  - compressing said melt between die surfaces at a pressure of less than 3,000 PSI, said die surfaces having recesses corresponding to the shape of said protrusions,
  - receiving said melt, including said 2%-15% by volume reinforcing particles, in said recesses so that said melt conforms to the shape of said recesses;
  - cooling said melt, wherein cooled portions of said melt received in said recesses form said reinforced protrusions.

7. A method according to claim 6, further comprising:  
placing a decorative material between said die surfaces and contacting said melt with said decorative material so as to adhere said decorative material to said melt.
8. A method according to claim 7, wherein said decorative material contacts a surface of said die cavity opposite said surface having said recesses.
9. A method according to claim 7, wherein said decorative material is made from a material selected from a group consisting of vinyl, PVC/ABS, TPO, PP, and TPU.
10. A method according to claim 7, wherein said decorative material includes a first layer made fabric, cloth, or carpeting, and a second layer comprising at least one of a bonded foam layer and a film layer disposed in contact with said first layer, said second layer contacting said melt between said die surfaces to prevent said melt from permeating through said first layer.



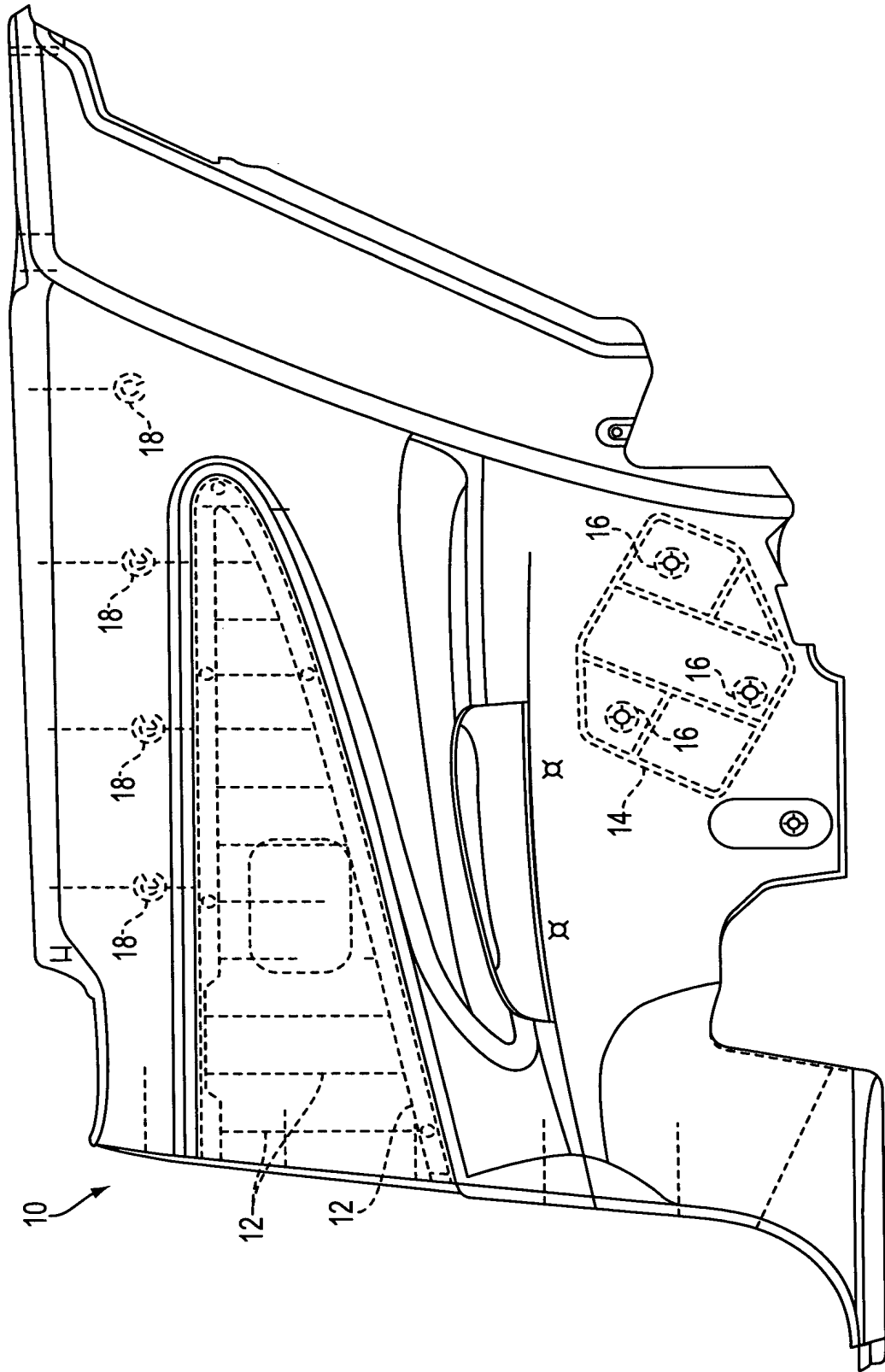


FIG. 1

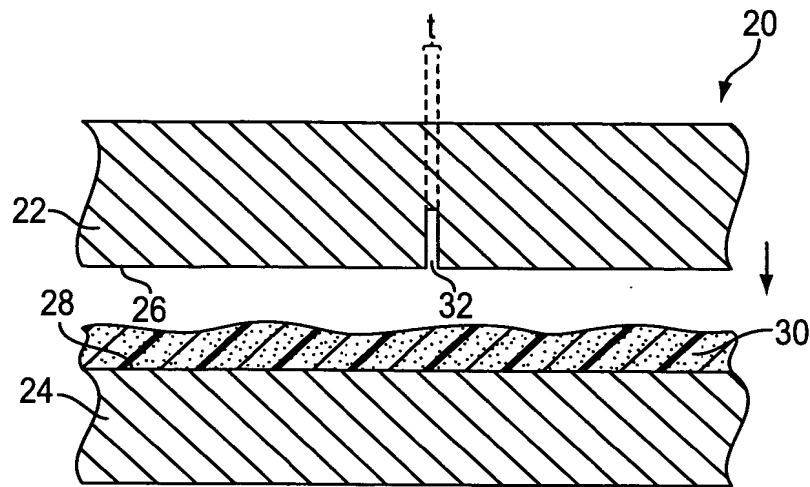


FIG. 2

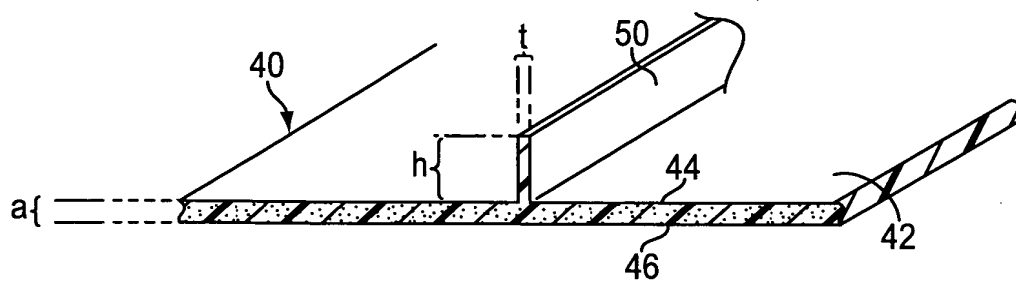


FIG. 3

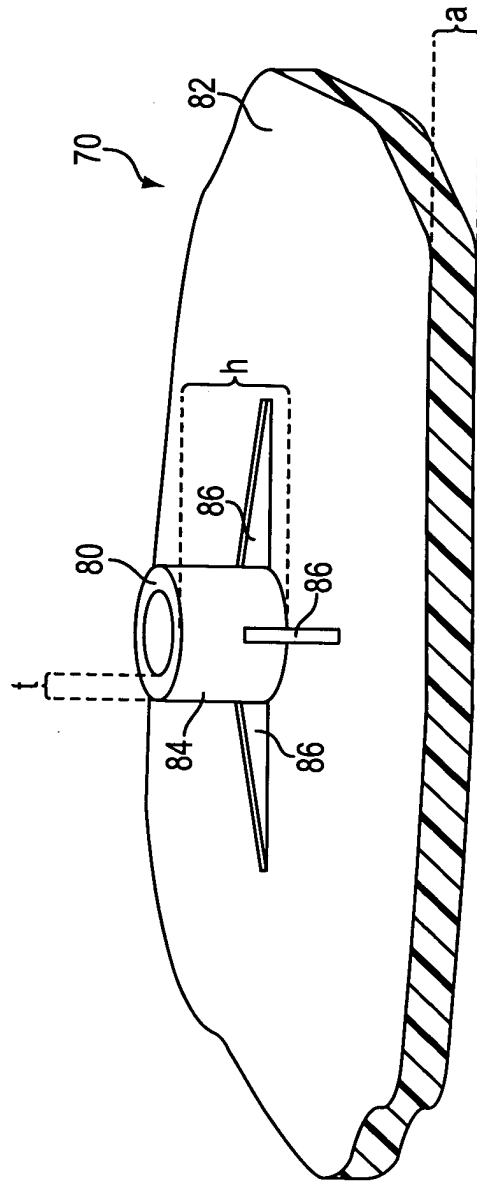


FIG. 4

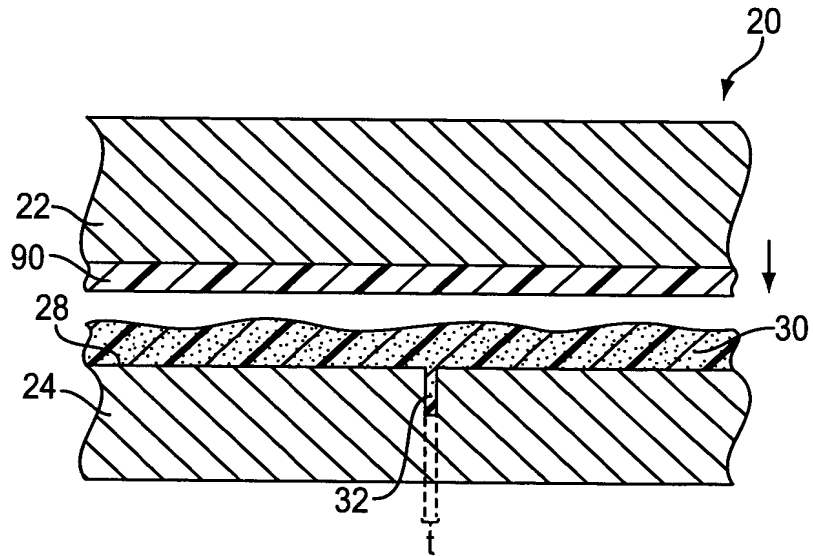


FIG. 5

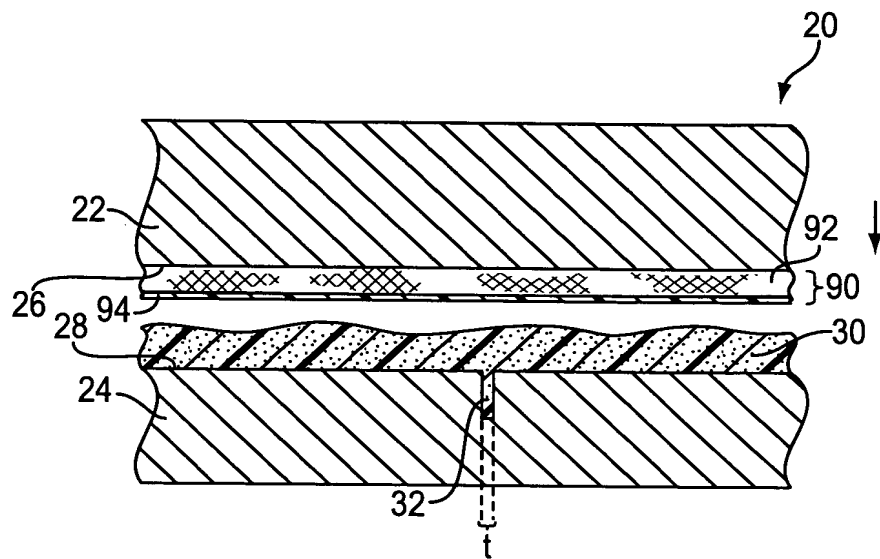


FIG. 6

# INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 99/29992

**A. CLASSIFICATION OF SUBJECT MATTER**  
IPC 7 B29C67/00 C08K3/34

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 B29C C08K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 4 739 007 A (OKADA AKANE ET AL) 19 April 1988 (1988-04-19) cited in the application abstract	1,6
Y	column 3, line 30 column 3, line 42 - line 48	2-5,7-10
Y	US 4 572 856 A (GEMBINSKI JOHN C) 25 February 1986 (1986-02-25) the whole document	2-5,7-10
X	US 5 747 560 A (MAXFIELD MACRAE ET AL) 5 May 1998 (1998-05-05) column 6, line 60 -column 24, line 49 -/--	1,6

☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

### \* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier document but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

"&" document member of the same patent family

Date of the actual completion of the international search

18 April 2000

Date of mailing of the international search report

28/04/2000

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2  
NL - 2280 HV Rijswijk  
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,  
Fax: (+31-70) 340-3016

Authorized officer

Philpott, G

# INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 99/29992

## C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
P,X	WO 99 61236 A (MAGNA INTERNATIONAL OF AMERICA ;WILSON PHILLIP S (US)) 2 December 1999 (1999-12-02) the whole document ---	1-10
P,X	WO 99 61237 A (MAGNA INTERNATIONAL OF AMERICA ;WILSON PHILLIP S (US)) 2 December 1999 (1999-12-02) the whole document ---	1-10
P,X	WO 99 61281 A (MAGNA INTERNATIONAL OF AMERICA ;WILSON PHILLIP S (US)) 2 December 1999 (1999-12-02) the whole document ---	1-10
P,X	WO 99 61287 A (MAGNA INTERNATIONAL OF AMERICA ;WILSON PHILLIP S (US)) 2 December 1999 (1999-12-02) the whole document ---	1-10
A	DE 196 25 797 A (VOLKSWAGENWERK AG) 9 January 1997 (1997-01-09) column 2, line 48 -column 4, line 4; claim 1 -----	1,6

# INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/US 99/29992

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
US 4739007	A	19-04-1988	JP 62252425 A	04-11-1987
			JP 8022946 B	06-03-1996
			JP 62074957 A	06-04-1987
			DE 3632865 A	02-04-1987
US 4572856	A	25-02-1986	NONE	
US 5747560	A	05-05-1998	AT 159270 T	15-11-1997
			CA 2115255 A	04-03-1993
			DE 69222773 D	20-11-1997
			DE 69222773 T	12-02-1998
			EP 0598836 A	01-06-1994
			JP 2674720 B	12-11-1997
			JP 6504810 T	02-06-1994
			WO 9304117 A	04-03-1993
			WO 9304118 A	04-03-1993
WO 9961236	A	02-12-1999	AU 4089099 A	13-12-1999
WO 9961237	A	02-12-1999	AU 4005799 A	13-12-1999
WO 9961281	A	02-12-1999	AU 4007499 A	13-12-1999
WO 9961287	A	02-12-1999	NONE	
DE 19625797	A	09-01-1997	NONE	

# PATENT COOPERATION TREATY

## PCT

### INTERNATIONAL PRELIMINARY EXAMINATION REPORT

(PCT Article 36 and Rule 70)

Applicant's or agent's file reference <b>MAGNA381PCT</b>	<b>FOR FURTHER ACTION</b> See Notification of Transmittal of International Preliminary Examination Report (Form PCT/IPEA/416)	
International application No. <b>PCT/US99/29992</b>	International filing date ( <i>day/month/year</i> ) <b>17/12/1999</b>	Priority date ( <i>day/month/year</i> ) <b>21/12/1998</b>
International Patent Classification (IPC) or national classification and IPC <b>B29C67/00</b>		
Applicant <b>MAGNA INTERNATIONAL OF AMERICA, INC. et al.</b>		

1. This international preliminary examination report has been prepared by this International Preliminary Examining Authority and is transmitted to the applicant according to Article 36.
2. This REPORT consists of a total of 5 sheets, including this cover sheet.  
  
☒ This report is also accompanied by ANNEXES, i.e. sheets of the description, claims and/or drawings which have been amended and are the basis for this report and/or sheets containing rectifications made before this Authority (see Rule 70.16 and Section 607 of the Administrative Instructions under the PCT).  
  
 These annexes consist of a total of 1 sheets.

3. This report contains indications relating to the following items:

- I ☒ Basis of the report
- II ☐ Priority
- III ☐ Non-establishment of opinion with regard to novelty, inventive step and industrial applicability
- IV ☐ Lack of unity of invention
- V ☒ Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement
- VI ☒ Certain documents cited
- VII ☒ Certain defects in the international application
- VIII ☐ Certain observations on the international application

Date of submission of the demand  <b>10/07/2000</b>	Date of completion of this report  <b>25.01.2001</b>
Name and mailing address of the international preliminary examining authority:  <div style="display: flex; align-items: center;"> <div>             European Patent Office              D-80298 Munich              Tel. +49 89 2399 - 0 Tx: 523656 epmu d              Fâx: +49 89 2399 - 4465           </div> </div>	Authorized officer  <b>Philpott, G</b>  Telephone No. +49 89 2399 8620





# INTERNATIONAL PRELIMINARY EXAMINATION REPORT

International application No. PCT/US99/29992

## I. Basis of the report

1. This report has been drawn on the basis of *(substitute sheets which have been furnished to the receiving Office in response to an invitation under Article 14 are referred to in this report as "originally filed" and are not annexed to the report since they do not contain amendments (Rules 70.16 and 70.17).):*

### Description, pages:

2-15	as originally filed		
1	as received on	11/01/2001	with letter of 08/01/2001

### Claims, No.:

1-10	as originally filed
------	---------------------

### Drawings, sheets:

1/4-4/4	as originally filed
---------	---------------------

2. With regard to the **language**, all the elements marked above were available or furnished to this Authority in the language in which the international application was filed, unless otherwise indicated under this item.

These elements were available or furnished to this Authority in the following language: , which is:

- ☐ the language of a translation furnished for the purposes of the international search (under Rule 23.1(b)).
- ☐ the language of publication of the international application (under Rule 48.3(b)).
- ☐ the language of a translation furnished for the purposes of international preliminary examination (under Rule 55.2 and/or 55.3).

3. With regard to any **nucleotide and/or amino acid sequence** disclosed in the international application, the international preliminary examination was carried out on the basis of the sequence listing:

- ☐ contained in the international application in written form.
- ☐ filed together with the international application in computer readable form.
- ☐ furnished subsequently to this Authority in written form.
- ☐ furnished subsequently to this Authority in computer readable form.
- ☐ The statement that the subsequently furnished written sequence listing does not go beyond the disclosure in the international application as filed has been furnished.
- ☐ The statement that the information recorded in computer readable form is identical to the written sequence listing has been furnished.

4. The amendments have resulted in the cancellation of:

# INTERNATIONAL PRELIMINARY EXAMINATION REPORT

International application No. PCT/US99/29992

- ☐ the description,      pages:  
☐ the claims,      Nos.:  
☐ the drawings,      sheets:

5. ☐ This report has been established as if (some of) the amendments had not been made, since they have been considered to go beyond the disclosure as filed (Rule 70.2(c)):

*(Any replacement sheet containing such amendments must be referred to under item 1 and annexed to this report.)*

6. Additional observations, if necessary:

## V. Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement

### 1. Statement

Novelty (N)	Yes:	Claims	1-10
	No:	Claims	
Inventive step (IS)	Yes:	Claims	
	No:	Claims	1-10
Industrial applicability (IA)	Yes:	Claims	1-10
	No:	Claims	

2. Citations and explanations  
**see separate sheet**

## VI. Certain documents cited

1. Certain published documents (Rule 70.10)

and / or

2. Non-written disclosures (Rule 70.9)

**see separate sheet**

## VII. Certain defects in the international application

The following defects in the form or contents of the international application have been noted:  
**see separate sheet**

**WRITTEN OPINION  
SEPARATE SHEET**

International application No. PCT/US99/29992

1. The first two paragraphs of claim 1 (A reinforced...thickness of said protrusion) are correctly cited in the description as part of the prior art. Thus, the only features of claim 1 which need to be assessed for inventiveness are those relating to the volume percent of particles in the protrusion, the particle layer constitution, and the platelet thickness.
2. US-A-4 739 007 (D1) teaches the use of reinforcing silicate layers, each layer being 0.7-1.2 nm thick, which is precisely the same range as given in the present application. D1 also teaches a silicate layer parts by 100 parts weight range of 0.5 - 150, which thus includes the 2%-15% volume range specified in present claim 1. D1 implies that the number of layers in each particle is low, but makes no explicit disclosure of any particular number of layers. However, US-A-5 747 560 (D2) further advises the skilled man on the incorporation into a plastic composite of platelet-based particles as a reinforcing agent, and explicitly states that the platelets comprise less than 10 layers. Moreover, the articles of D2 may be embossed, which correlates with the protrusions of present claim 1. All of the above features are therefore taught by the prior art, and as such claim 1 (and by logical extension claim 6) fail to meet the requirements of Art. 33(3) PCT.
3. Claims 2-5 and 7-10 deal with standard manufacturing techniques related to car panels, and do not add anything to the subject matter concerning nano-particle reinforcement. Whilst such techniques are well-known in the art, US-A-4 572 856, relating to automobile dashboard production, is cited by way of example. As such, these claims could not form the basis for an inventive (Art. 33(3) PCT) independent claim.
4. With respect to Rule 70.10 PCT, attention is drawn to WO9961236, WO9961237 and WO9961287, all published on 021299 and all filed on 200599 and all with a US priority date of 220598.
5. D1-D3 are not incorporated into the description ((Rule 5.1(a)(ii) PCT).
6. The two-part claim style is not used (Rule 6.3 PCT).
7. The paragraph on page 15 render the scope of the application ambiguous, and

**WRITTEN OPINION  
SEPARATE SHEET**

---

International application No. PCT/US99/29992

should be deleted (PCT Preliminary Examination Guidelines-III-4.3a).

8. Technical features in the claims are not followed by reference signs to the drawings (Rule 6.2(b) PCT).

**LOW PRESSURE COMPRESSION MOLDED PARTS HAVING  
NANO-PARTICLE REINFORCED PROTRUSIONS  
AND METHOD OF MAKING THE SAME**

5        This patent application claims priority from U.S. Provisional Application No. 60/113,133  
filed December 21, 1998.

**BACKGROUND OF THE INVENTION**

10        Automobile interior trim is often engineered to minimize wall thickness, while  
maintaining desired structural characteristics. Greater wall thickness of such molded articles  
requires more raw material per unit part, thereby undesirably increasing the cost of production  
and increasing vehicle weight. Furthermore, greater wall thicknesses slow down production time  
due to longer cycling periods needed to permit cooling of thicker molded regions.

15        Automotive trim components or articles, such as interior panels are often molded from  
thermoplastic to have various protrusions extending from a broad panel surface, which protrusions  
serve different functions. For example, some trim components are provided with stiffening ribs to  
reduce twisting or flexing of the part. The same or other trim components may be provided with  
fastening bosses that add rigidity and/or strength to areas of the part that are to be secured or  
fastened to another structure. For example, a screw receiving hole in a molded article may be  
20        surrounded by an annular protrusion for support. Such annular protrusion may also have radially  
outwardly extending protrusions (as an asterisk) to provide further support. As another example,  
standoffs may be formed on the broad surface of the part to provide proper spacing from an abutting  
component. As a further example, a protrusion may be in the form of

# REQUEST

The undersigned requests that the present international application be processed according to the Patent Cooperation Treaty.

For receiving Office use only

International Application No.

International Filing Date

Name of receiving Office and "PCT International Application"

Applicant's or agent's file reference (if desired) (12 characters maximum) MAGNA381PCT

## Box No. I TITLE OF INVENTION

LOW PRESSURE COMPRESSION MOLDED PARTS HAVING NANO-PARTICLE REINFORCED PROTRUSIONS AND METHOD OF MAKING THE SAME

## Box No. II APPLICANT

Name and address: (Family name followed by given name; for a legal entity, full official designation. The address must include postal code and name of country. The country of the address indicated in this Box is the applicant's State (that is, country) of residence if no State of residence is indicated below.)

MAGNA INTERNATIONAL OF AMERICA, INC.  
600 Wilshire Drive  
Troy Michigan 48084  
United States of America

☐ This person is also inventor.

Telephone No.

Facsimile No.

Teleprinter No.

State (that is, country) of nationality:  
US

State (that is, country) of residence:  
US

This person is applicant for the purposes of: ☐ all designated States ☒ all designated States except the United States of America ☐ the United States of America only ☐ the States indicated in the Supplemental Box

## Box No. III FURTHER APPLICANT(S) AND/OR (FURTHER) INVENTOR(S)

Name and address: (Family name followed by given name; for a legal entity, full official designation. The address must include postal code and name of country. The country of the address indicated in this Box is the applicant's State (that is, country) of residence if no State of residence is indicated below.)

WILSON, Phillip S.  
5480 Huron Hill Drive  
Commerce Township, Michigan 48382  
United States of America

This person is:

☐ applicant only

☒ applicant and inventor

☐ inventor only (If this check-box is marked, do not fill in below.)

State (that is, country) of nationality:  
US

State (that is, country) of residence:  
US

This person is applicant for the purposes of: ☐ all designated States ☐ all designated States except the United States of America ☒ the United States of America only ☐ the States indicated in the Supplemental Box

☐ Further applicants and/or (further) inventors are indicated on a continuation sheet.

## Box No. IV AGENT OR COMMON REPRESENTATIVE; OR ADDRESS FOR CORRESPONDENCE

The person identified below is hereby/has been appointed to act on behalf of the applicant(s) before the competent International Authorities as:

☒ agent ☐ common representative

Name and address: (Family name followed by given name; for a legal entity, full official designation. The address must include postal code and name of country.)

BARUFKA, Jack S.  
PILLSBURY MADISON & SUTRO LLP  
1100 New York Avenue, N.W.  
Washington, D.C. 20005  
United States of America

Telephone No.  
202 861 3000

Facsimile No.  
202 822 0944

Teleprinter No.

☐ Address for correspondence: Mark this check-box where no agent or common representative is/has been appointed and the space above is used instead to indicate a special address to which correspondence should be sent.

Box No.V

## DESIGNATION OF STATES

The following designations are hereby made under Rule 4.9(a) (mark the applicable check-boxes; at least one must be marked):

## Regional Patent

- ☒ **AP ARIPO Patent:** GH Ghana, GM Gambia, KE Kenya, LS Lesotho, MW Malawi, SD Sudan, SL Sierra Leone, SZ Swaziland, UG Uganda, ZW Zimbabwe, and any other State which is a Contracting State of the Harare Protocol and of the PCT
- ☒ **EA Eurasian Patent:** AM Armenia, AZ Azerbaijan, BY Belarus, KG Kyrgyzstan, KZ Kazakhstan, MD Republic of Moldova, RU Russian Federation, TJ Tajikistan, TM Turkmenistan, and any other State which is a Contracting State of the Eurasian Patent Convention and of the PCT
- ☒ **EP European Patent:** AT Austria, BE Belgium, CH and LI Switzerland and Liechtenstein, CY Cyprus, DE Germany, DK Denmark, ES Spain, FI Finland, FR France, GB United Kingdom, GR Greece, IE Ireland, IT Italy, LU Luxembourg, MC Monaco, NL Netherlands, PT Portugal, SE Sweden, and any other State which is a Contracting State of the European Patent Convention and of the PCT
- ☒ **OA OAPI Patent:** BF Burkina Faso, BJ Benin, CF Central African Republic, CG Congo, CI Cote d'Ivoire, CM Cameroon, GA Gabon, GN Guinea, GW Guinea-Bissau, ML Mali, MR Mauritania, NE Niger, SN Senegal, TD Chad, TG Togo, and any other State which is a member State of OAPI and a Contracting State of the PCT (if other kind of protection or treatment desired, specify on dotted line) .....

## National Patent (if other kind of protection or treatment desired, specify on dotted line):

- |  |  |
|--|--|
| <input checked="" type="checkbox"/> AE United Arab Emirates                  | <input checked="" type="checkbox"/> LR Liberia                                   |
| <input checked="" type="checkbox"/> AL Albania                               | <input checked="" type="checkbox"/> LS Lesotho                                   |
| <input checked="" type="checkbox"/> AM Armenia                               | <input checked="" type="checkbox"/> LT Lithuania                                 |
| <input checked="" type="checkbox"/> AT Austria                               | <input checked="" type="checkbox"/> LU Luxembourg                                |
| <input checked="" type="checkbox"/> AU Australia                             | <input checked="" type="checkbox"/> LV Latvia                                    |
| <input checked="" type="checkbox"/> AZ Azerbaijan                            | <input checked="" type="checkbox"/> MD Republic of Moldova                       |
| <input checked="" type="checkbox"/> BA Bosnia and Herzegovina                | <input checked="" type="checkbox"/> MG Madagascar                                |
| <input checked="" type="checkbox"/> BB Barbados                              | <input checked="" type="checkbox"/> MK The former Yugoslav Republic of Macedonia |
| <input checked="" type="checkbox"/> BG Bulgaria                              | <input checked="" type="checkbox"/> MN Mongolia                                  |
| <input checked="" type="checkbox"/> BR Brazil                                | <input checked="" type="checkbox"/> MW Malawi                                    |
| <input checked="" type="checkbox"/> BY Belarus                               | <input checked="" type="checkbox"/> MX Mexico                                    |
| <input checked="" type="checkbox"/> CA Canada                                | <input checked="" type="checkbox"/> NO Norway                                    |
| <input checked="" type="checkbox"/> CH and LI Switzerland and Liechtenstein  | <input checked="" type="checkbox"/> NZ New Zealand                               |
| <input checked="" type="checkbox"/> CN China                                 | <input checked="" type="checkbox"/> PL Poland                                    |
| <input checked="" type="checkbox"/> CU Cuba                                  | <input checked="" type="checkbox"/> PT Portugal                                  |
| <input checked="" type="checkbox"/> CZ Czech Republic                        | <input checked="" type="checkbox"/> RO Romania                                   |
| <input checked="" type="checkbox"/> DE Germany                               | <input checked="" type="checkbox"/> RU Russian Federation                        |
| <input checked="" type="checkbox"/> DK Denmark                               | <input checked="" type="checkbox"/> SD Sudan                                     |
| <input checked="" type="checkbox"/> EE Estonia                               | <input checked="" type="checkbox"/> SE Sweden                                    |
| <input checked="" type="checkbox"/> ES Spain                                 | <input checked="" type="checkbox"/> SG Singapore                                 |
| <input checked="" type="checkbox"/> FI Finland                               | <input checked="" type="checkbox"/> SI Slovenia                                  |
| <input checked="" type="checkbox"/> GB United Kingdom                        | <input checked="" type="checkbox"/> SK Slovakia                                  |
| <input checked="" type="checkbox"/> GD Grenada                               | <input checked="" type="checkbox"/> SL Sierra Leone                              |
| <input checked="" type="checkbox"/> GE Georgia                               | <input checked="" type="checkbox"/> TJ Tajikistan                                |
| <input checked="" type="checkbox"/> GH Ghana                                 | <input checked="" type="checkbox"/> TM Turkmenistan                              |
| <input checked="" type="checkbox"/> GM Gambia                                | <input checked="" type="checkbox"/> TR Turkey                                    |
| <input checked="" type="checkbox"/> HR Croatia                               | <input checked="" type="checkbox"/> TT Trinidad and Tobago                       |
| <input checked="" type="checkbox"/> HU Hungary                               | <input checked="" type="checkbox"/> UA Ukraine                                   |
| <input checked="" type="checkbox"/> ID Indonesia                             | <input checked="" type="checkbox"/> UG Uganda                                    |
| <input checked="" type="checkbox"/> IL Israel                                | <input checked="" type="checkbox"/> US United States of America                  |
| <input checked="" type="checkbox"/> IN India                                 | <input checked="" type="checkbox"/> continuation                                 |
| <input checked="" type="checkbox"/> IS Iceland                               | <input checked="" type="checkbox"/> UZ Uzbekistan                                |
| <input checked="" type="checkbox"/> JP Japan                                 | <input checked="" type="checkbox"/> VN Viet Nam                                  |
| <input checked="" type="checkbox"/> KE Kenya                                 | <input checked="" type="checkbox"/> YU Yugoslavia                                |
| <input checked="" type="checkbox"/> KG Kyrgyzstan                            | <input checked="" type="checkbox"/> ZA South Africa                              |
| <input checked="" type="checkbox"/> KP Democratic People's Republic of Korea | <input checked="" type="checkbox"/> ZW Zimbabwe                                  |
| <input checked="" type="checkbox"/> KR Republic of Korea                     |  |
| <input checked="" type="checkbox"/> KZ Kazakhstan                            |  |
| <input checked="" type="checkbox"/> LC Saint Lucia                           |  |
| <input checked="" type="checkbox"/> LK Sri Lanka                             |  |

Check-boxes reserved for designating States which have become party to the PCT after issuance of this sheet:

- ☒ CR Costa Rica    ☒ TZ United Republic of Tanzania  
☒ DM Dominica    ☒ -MA Morocco

**Precautionary Designation Statement:** In addition to the designations made above, the applicant also makes under Rule 4.9(b) all other designations which would be permitted under the PCT except any designation(s) indicated in the Supplemental Box as being excluded from the scope of this statement. The applicant declares that those additional designations are subject to confirmation and that any designation which is not confirmed before the expiration of 15 months from the priority date is to be regarded as withdrawn by the applicant at the expiration of that time limit. (Confirmation of a designation consists of the filing of a notice specifying that designation and the payment of the designation and confirmation fees. Confirmation must reach the receiving Office within the 15-month time limit.)

## Supplemental Box

If the Supplemental Box is not used, this sheet need not be included in the request.

1. If, in any of the Boxes, the space is insufficient to furnish all the information: in such case, write "Continuation of Box No. ..." [indicate the number of the Box] and furnish the information in the same manner as required according to the captions of the Box in which the space was insufficient, in particular:
- (i) if more than two persons are involved as applicants and/or inventors and no "continuation sheet" is available: in such case, write "Continuation of Box No. III" and indicate for each additional person the same type of information as required in Box No. III. The country of the address indicated in this Box is the applicant's State (that is, country) of residence if no State of residence is indicated below;
  - (ii) if, in Box No. II or in any of the sub-boxes of Box No. III, the indication "the States indicated in the Supplemental Box" is checked: in such case, write "Continuation of Box No. II" or "Continuation of Box No. III" or "Continuation of Boxes No. II and No. III" (as the case may be), indicate the name of the applicant(s) involved and, next to (each) such name, the State(s) (and/or, where applicable, ARIPO, Eurasian, European or OAPI patent) for the purposes of which the named person is applicant;
  - (iii) if, in Box No. II or in any of the sub-boxes of Box No. III, the inventor or the inventor/applicant is not inventor for the purposes of all designated States or for the purposes of the United States of America: in such case, write "Continuation of Box No. II" or "Continuation of Box No. III" or "Continuation of Boxes No. II and No. III" (as the case may be), indicate the name of the inventor(s) and, next to (each) name, the State(s) (and/or, where applicable, ARIPO, Eurasian, European or OAPI patent) for the purposes of which the named person is inventor;
  - (iv) if, in addition to the agent(s) indicated in Box IV, there are further agents: in such case, write "Continuation of Box No. IV" and indicate for each further agent the same type of information as required in Box No. IV;
  - (v) if, in Box No. V, the name of any State (or OAPI) is accompanied by the indication "patent of addition," or "certificate of addition," or if, in Box No. V., the name of the United States of America is accompanied by an indication "continuation" or "continuation-in-part": in such case, write "Continuation of Box No. V" and the name of each State involved (or OAPI), and after the name of each such State (or OAPI), the number of the parent title or parent application and the date of grant of the parent title or filing of the parent application;
  - (vi) if, in Box No. VI, there are more than three earlier applications whose priority is claimed: in such case, write "Continuation of Box No. VI" and indicate for each additional earlier application the same type of information as required in Box No. VI;
  - (vii) if, in Box No. VI, the earlier application is an ARIPO application: in such case, write "Continuation of Box No. VI", specify the number of the item corresponding to that earlier application and indicate at least one country party to the Paris Convention for the Protection of Industrial Property for which that earlier application was filed.
2. If, with regard to the precautionary designation statement contained in Box No. V, the applicant wishes to exclude any State(s) from the scope of that statement: in such case, write "Designation(s) excluded from precautionary designation statement" and indicate the name or two-letter code of each State so excluded.
3. If the applicant claims, in respect of any designated Office, the benefits of provisions of the national law concerning non-prejudicial disclosures or exceptions to lack of novelty: in such case, write "Statement concerning non-prejudicial disclosures or exceptions to lack of novelty" and furnish that statement below.

## Box No. IV. Agent or Common Representative: (continued)

KOKULIS, Paul N.	BIRD, Donald J.	EDGEELL, G. Paul
LIPPITT, Raymond F.	ECCLESTON, Lynn E.	JAKOPIN, David A.
KNIGHT, G. Lloyd	GOWDEY Peter W.	PAULSON, Mark G.
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MARTIN, Edgar H.	PERRY, Glenn J.	McQUADE, Paul F.
COLTON, Kendrew H.	MORDUCH, Ruth N.	DZWONCZYK, Michael R.
JOYCE, Kevin E.	WHITE, Paul E., Jr.	SIRILLA, George M.
WISE, Roger R.	BENGTTSSON, W. Patrick	
ZAITLEN, Richard H.	SMYRSKI, Steven W	KIRKPATRICK, Anita M.
HESS, Adam R.	GLAZIER, Stephen C.	
FINKELSTEIN, Jay M.	NAGY, Paul G.	

All attorneys are partners of the firm of PILLSBURY MADISON & SUTRO, LLP. The address, telephone number, and facsimile number of all the above attorneys are as indicated in Box IV.

## Box No. V Designation of States (continued)

US: 60/113,133 filed 21 December 1998 (21.12.98)



Box No. VI PRIORITY CLAIM				
Filing date of earlier application (day/month/year)	Number of earlier application	<input type="checkbox"/> Further priority claims indicated in the Supplemental Box.		
		Where earlier application is:		
		national application: country	regional application: regional Office	international application: receiving Office
item (1) 21 December 1998 (21.12.98)	60/113,133	US		
item (2)				
item (3)				

☒ The receiving Office is requested to prepare and transmit to the International Bureau a certified copy of the earlier application(s) (only if the earlier application was filed with the Office which for the purposes of the present international application is the receiving Office) identified above as item(s): (1)

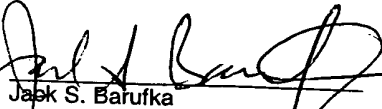
\* Where the earlier application is an ARIPO application, it is mandatory to indicate in the Supplemental Box at least one country party to the Paris Convention for the Protection of Industrial Property for which that earlier application was filed (Rule 4.10(b)(ii)). See Supplemental Box.

Box No. VII INTERNATIONAL SEARCHING AUTHORITY			
Choice of International Searching Authority (ISA) (if two or more International Searching Authorities are competent to carry out the international search, indicate the Authority chosen; the two-letter code may be used):		Request to use results of earlier search; reference to that search (if an earlier search has been carried out by or requested from the International Searching Authority):	
ISA/EP		Date (day/month/year)	Number Country (or regional Office)

Box No. VIII CHECK LIST: LANGUAGE OF FILING	
This international application contains the following number of sheets: request : 4 description (excluding sequence listing part) : 15 claims : 3 abstract : 1 drawings : 4 sequence listing part of description : Total number of sheets : 27	This international application is accompanied by the item(s) marked below: 1. <input checked="" type="checkbox"/> fee calculation sheet 2. <input type="checkbox"/> separate signed power of attorney 3. <input type="checkbox"/> copy of general power of attorney; reference number, if any: 4. <input type="checkbox"/> statement explaining lack of signature 5. <input type="checkbox"/> priority document(s) identified in Box No. VI as item(s): 6. <input type="checkbox"/> translation of international application into (language): 7. <input type="checkbox"/> separate indications concerning deposited microorganism or other biological material 8. <input type="checkbox"/> nucleotide and/or amino acid sequence listing in computer readable form 9. <input checked="" type="checkbox"/> other (specify): Transmittal Fee to US/RO and return post card
Figure of the drawings which should accompany the abstract:	Language of filing of the international application: ENGLISH

Box No. IX SIGNATURE OF APPLICANT OR AGENT

Next to each signature, indicate the name of the person signing and the capacity in which the person signs (if such capacity is not obvious from reading the request).

  
Jack S. Barufka

1. Date of actual receipt of the purported international application:		For receiving Office use only	
3. Corrected date of actual receipt due to later but timely received papers or drawings completing the purported international application:			
4. Date of timely receipt of the required corrections under PCT Article 11(2):			
5. International Searching Authority (if two or more are competent): ISA/		6. <input type="checkbox"/> Transmittal of search copy delayed until search fee is paid	
		2. Drawings: <input type="checkbox"/> received: <input type="checkbox"/> not received:	

Date of receipt of the record copy by the International Bureau:

For International Bureau use only

# PCT

## FEE CALCULATION SHEET

Annex to the Request

For receiving Office use only

International application No.

Date stamp of the receiving Office

Applicant's or agent's  
file reference

MAGNA381PCT

Applicant

MAGNA INTERNATIONAL OF AMERICA, INC.

### CALCULATION OF PRESCRIBED FEES

#### 1. TRANSMITTAL FEE

240.00 T

#### 2. SEARCH FEE

International search to be carried out by

EP

1,002.00 S

(If two or more International Searching Authorities are competent in relation to the international application, indicate the name of the Authority which is chosen to carry out the international search.)

#### 3. INTERNATIONAL FEE

##### Basic Fee

The international application contains 27 sheets.

first 30 sheets

455.00 b<sub>1</sub>

0

x

remaining sheets

additional amount

=

0.00 b<sub>2</sub>

Add amounts entered at b<sub>1</sub> and b<sub>2</sub> and enter total at B

455.00 B

##### Designation Fees

The international application contains all designations.

10

x

105.00

=

1,050.00 D

number of designation fees  
payable (maximum 10)

amount of designation fee

Add amounts entered at B and D and enter total at I

1,505.00 I

(Applicants from certain States are entitled to a reduction of 75% of the international fee. Where the applicant is (or all applicants are) so entitled, the total to be entered at I is 25% of the sum of the amounts entered at B and D.)

#### 4. FEE FOR PRIORITY DOCUMENT (if applicable)

15.00 P

#### 5. TOTAL FEES PAYABLE

Add amounts entered at T, S, I and P, and enter total in the TOTAL box

2,762.00

TOTAL

☐ The designation fees are not paid at this time.

### MODE OF PAYMENT

☒ authorization to charge  
deposit account (see below)

☐ bank draft

☐ coupons

☒ cheque

☐ cash

☐ other (specify):

☐ postal money order

☐ revenue stamps

### DEPOSIT ACCOUNT AUTHORIZATION

(this mode of payment may not be available at all receiving Offices)

The RO/ US

☐

is hereby authorized to charge the total fees indicated above to my deposit account.

☒

(this check-box may be marked only if the conditions for deposit accounts of the receiving Office so permit) is hereby authorized to charge any deficiency or credit any overpayment in the total fees indicated above to my deposit account.

☐

is hereby authorized to charge the fee for preparation and transmittal of the priority document to the International Bureau of WIPO to my deposit account.

03-3975

17 December 1999

Deposit Account Number

Date (day/month/year)

Signature